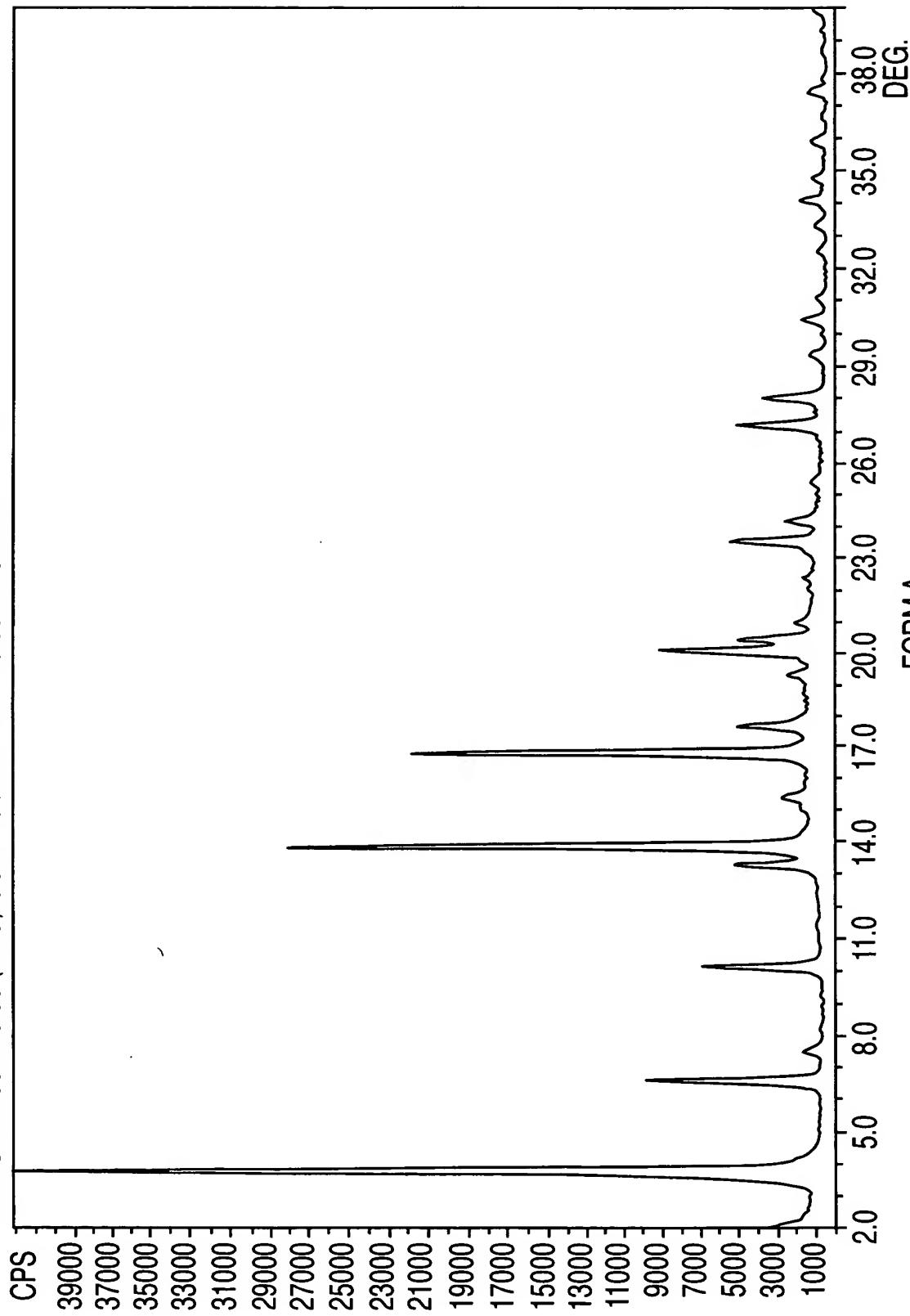




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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



⊗

FIG. 1
FORM A

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

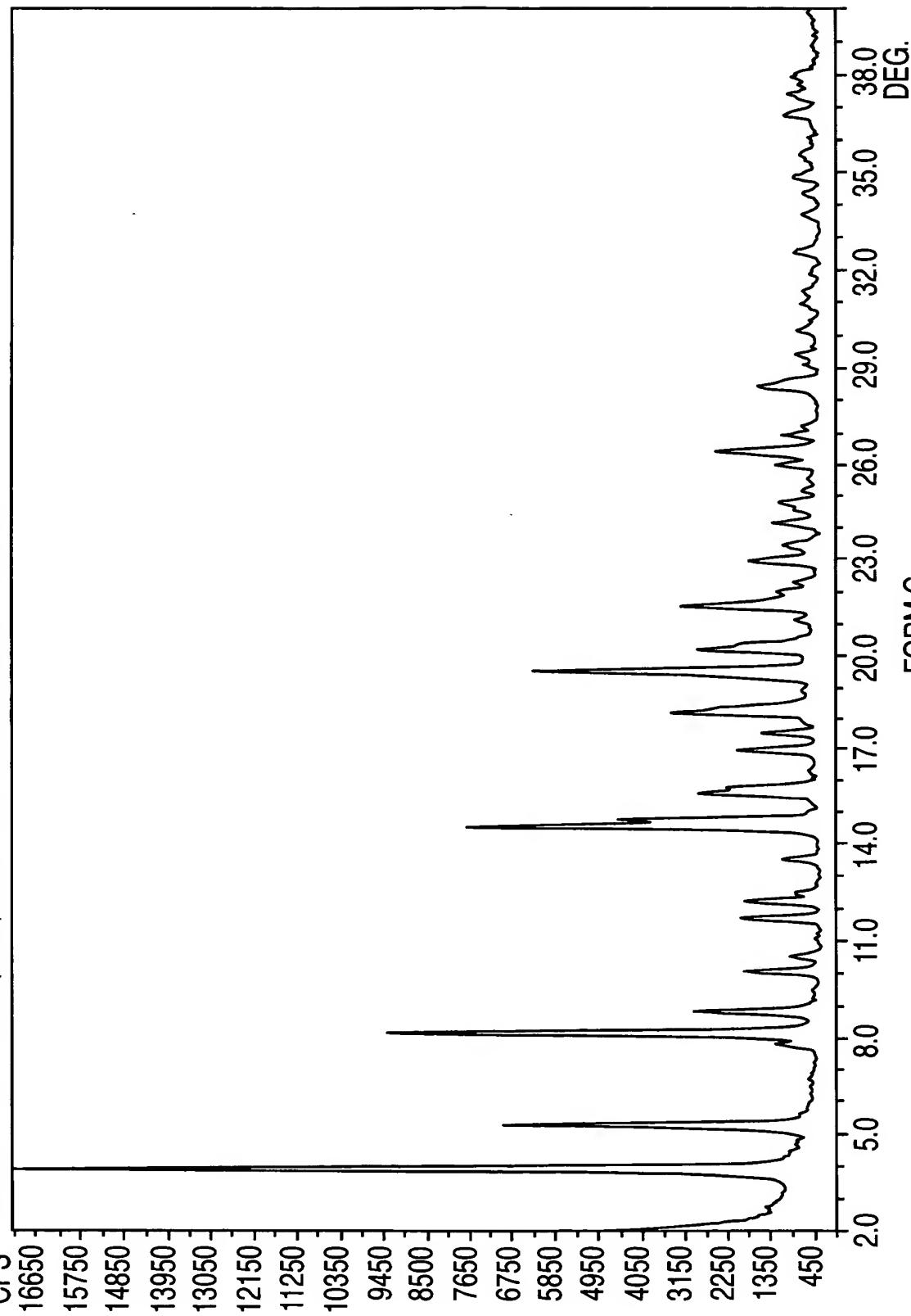
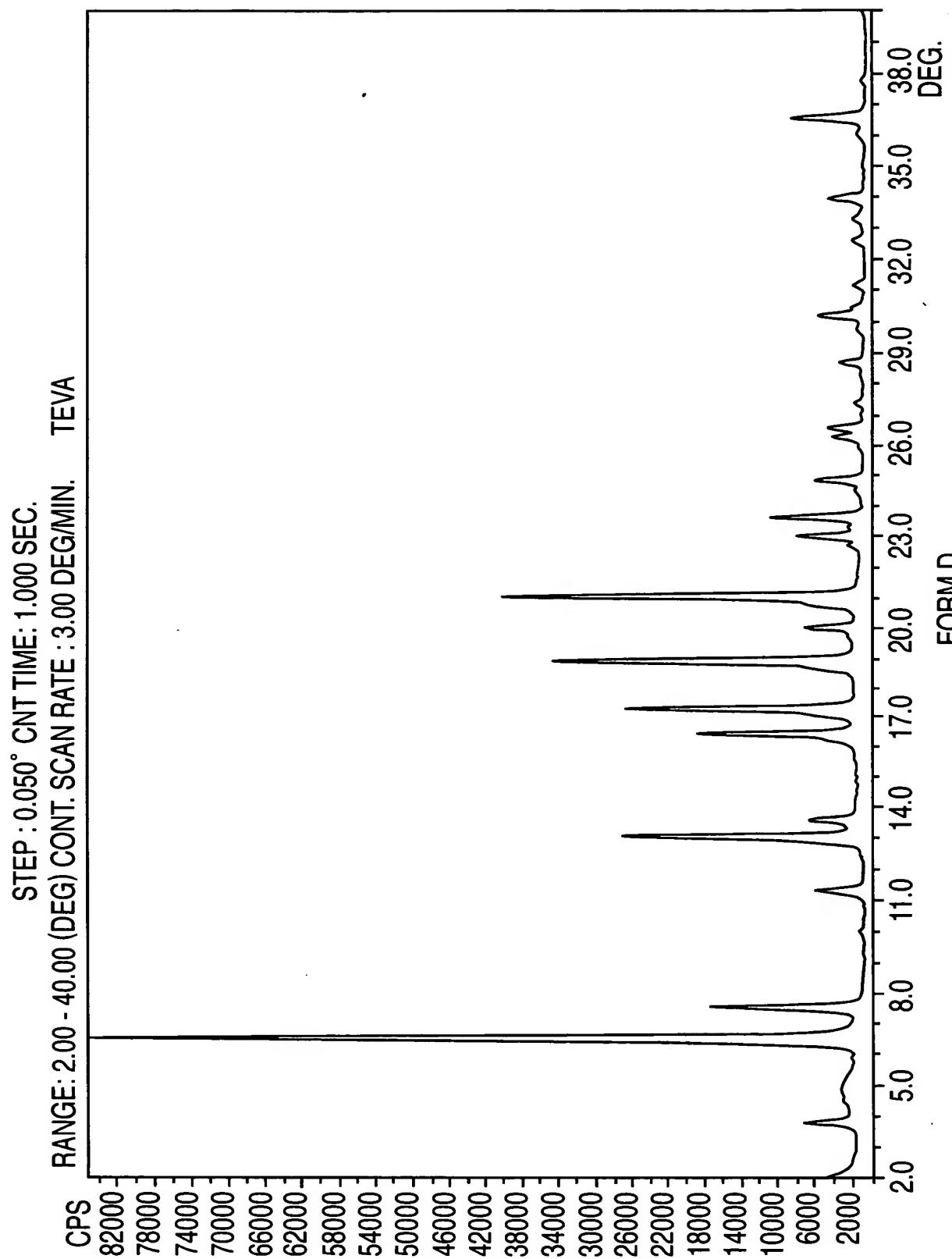


FIG. 2
FORM C

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FORM D
FIG. 3

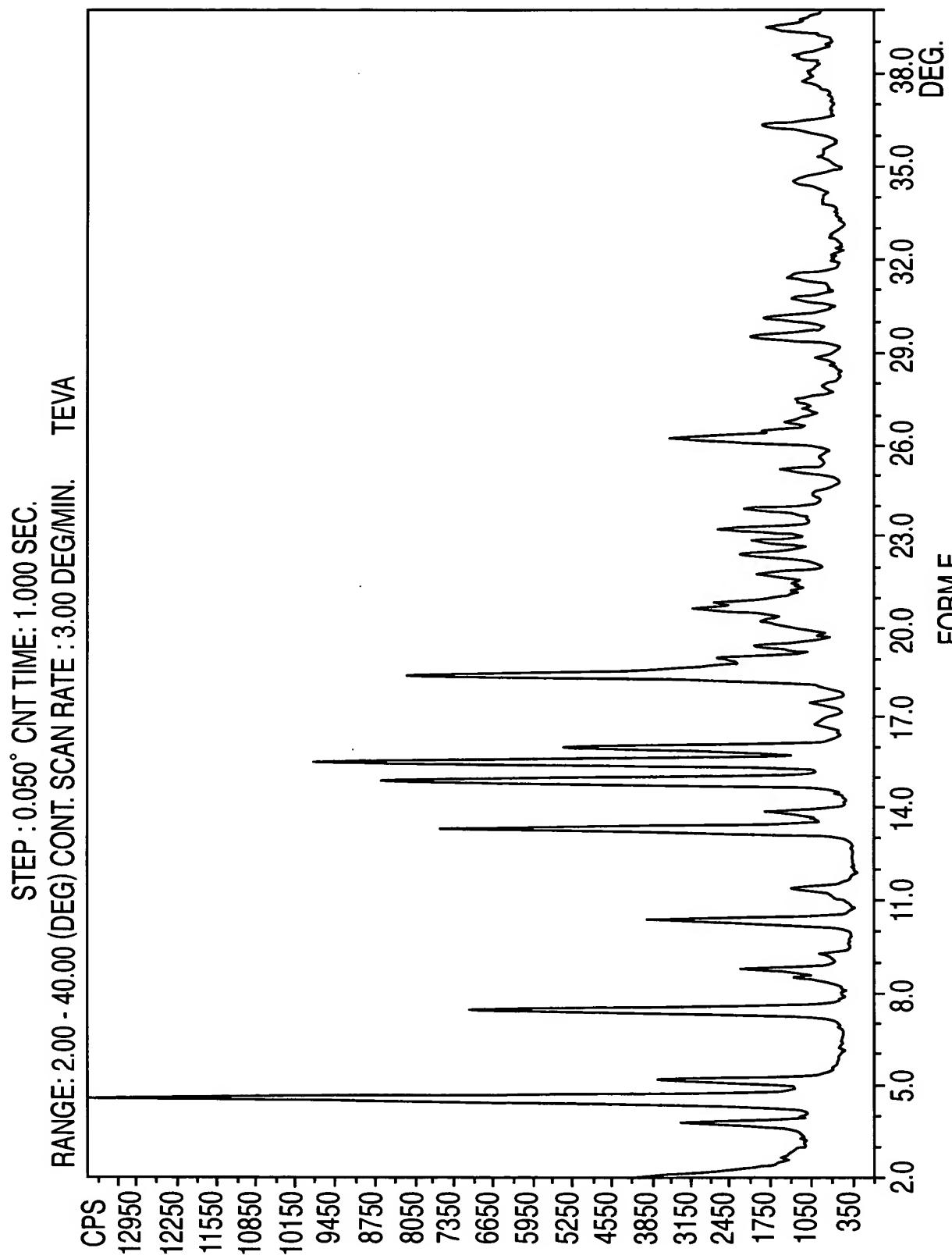
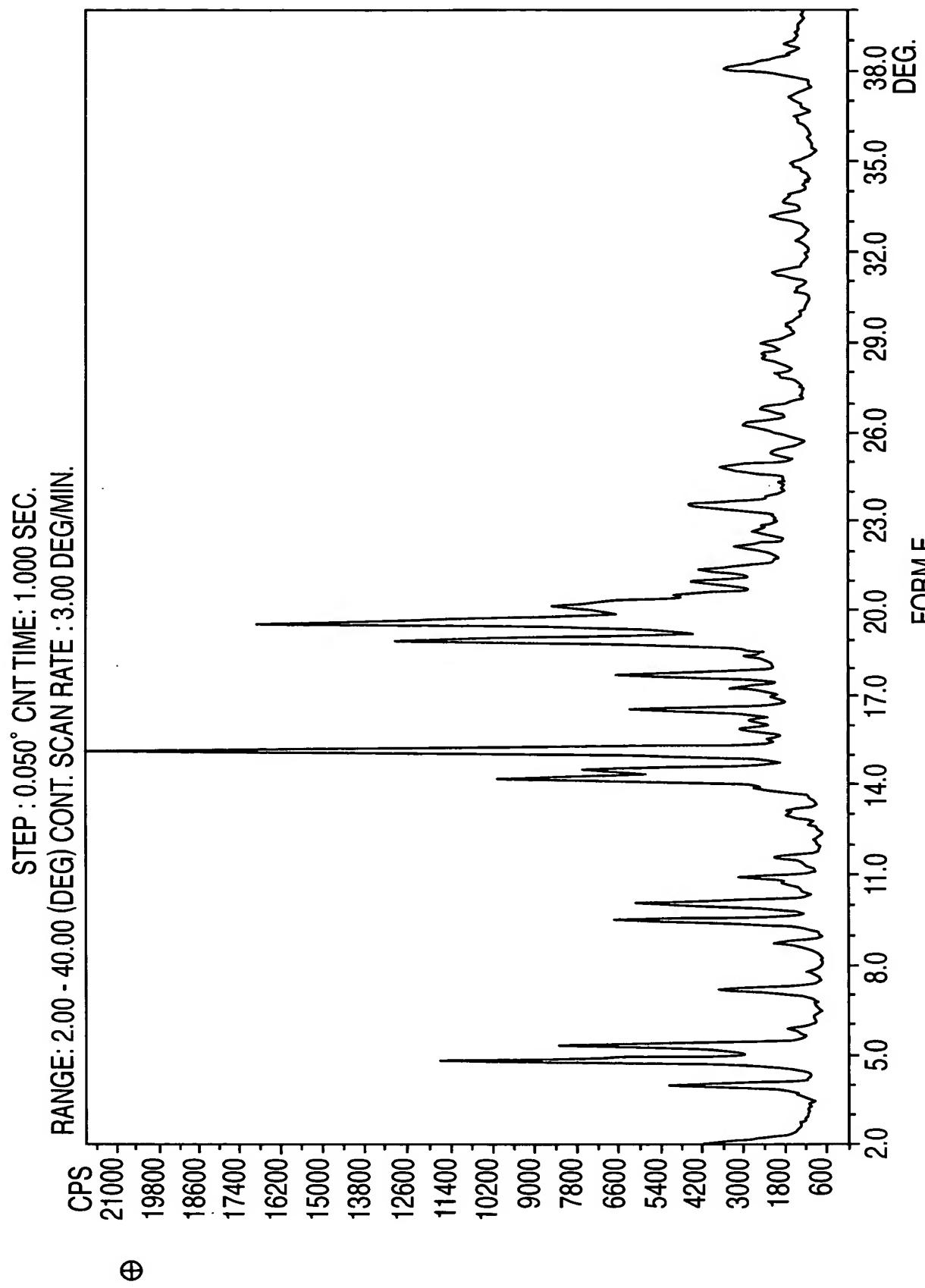
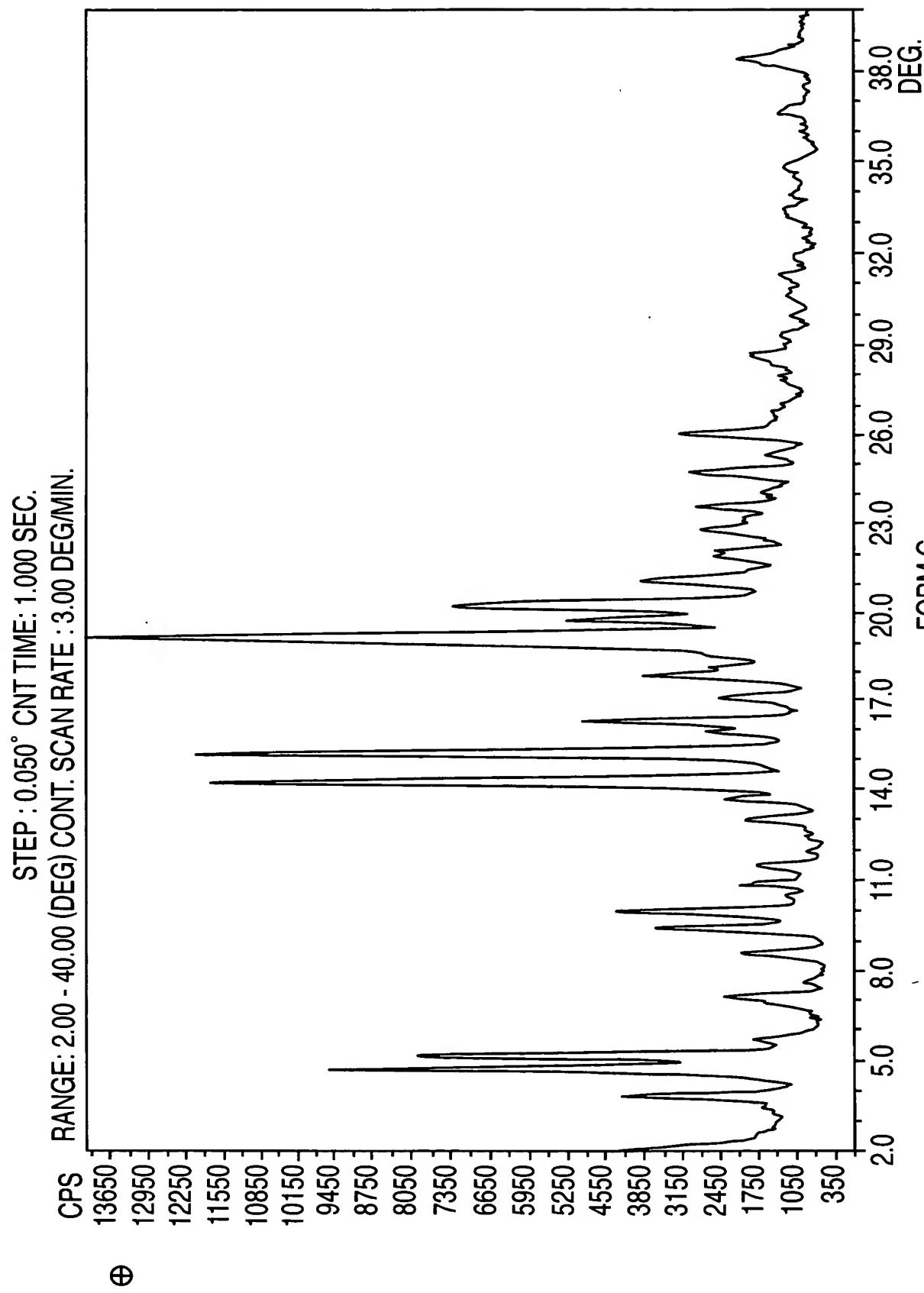


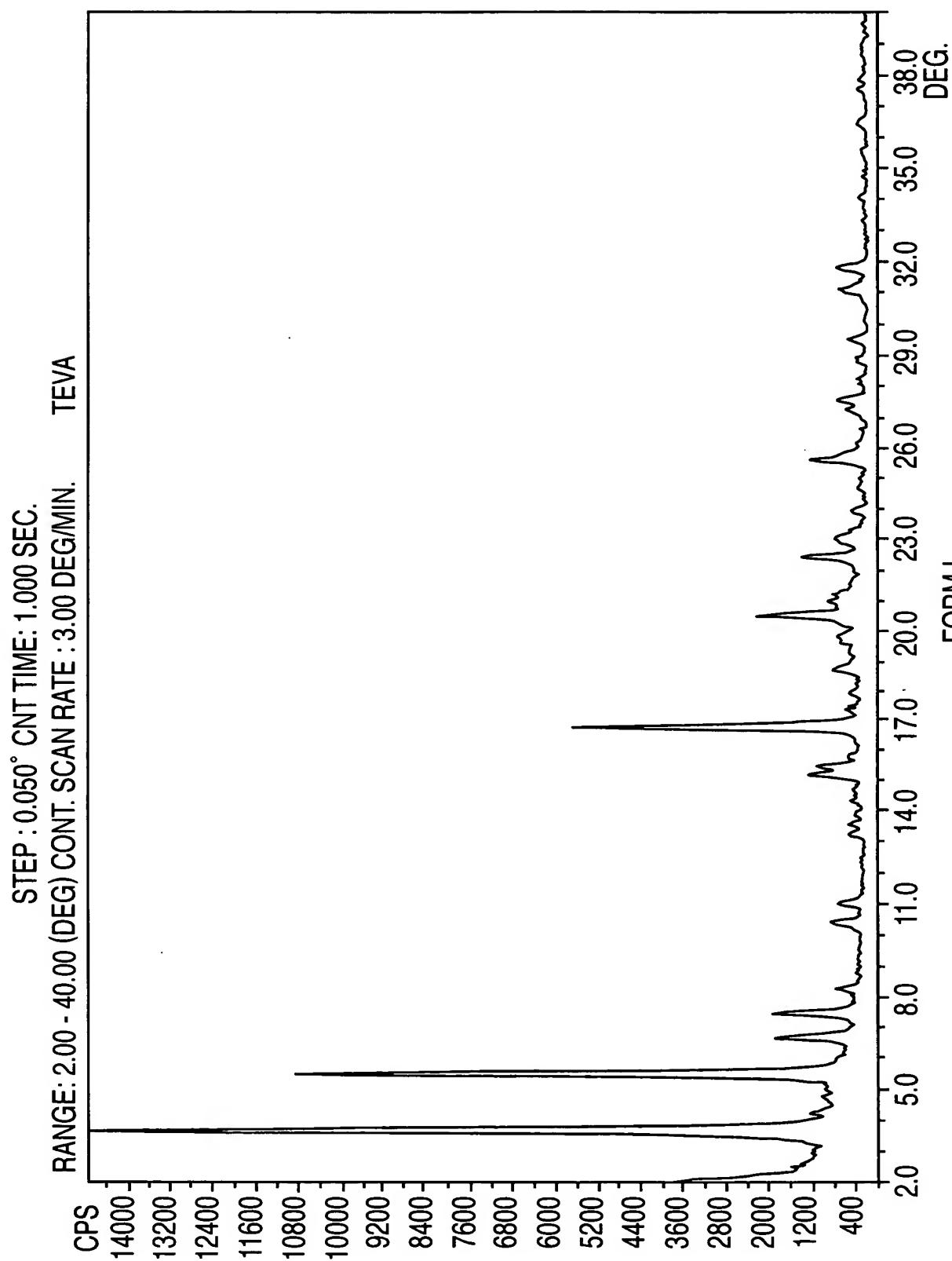
FIG. 4

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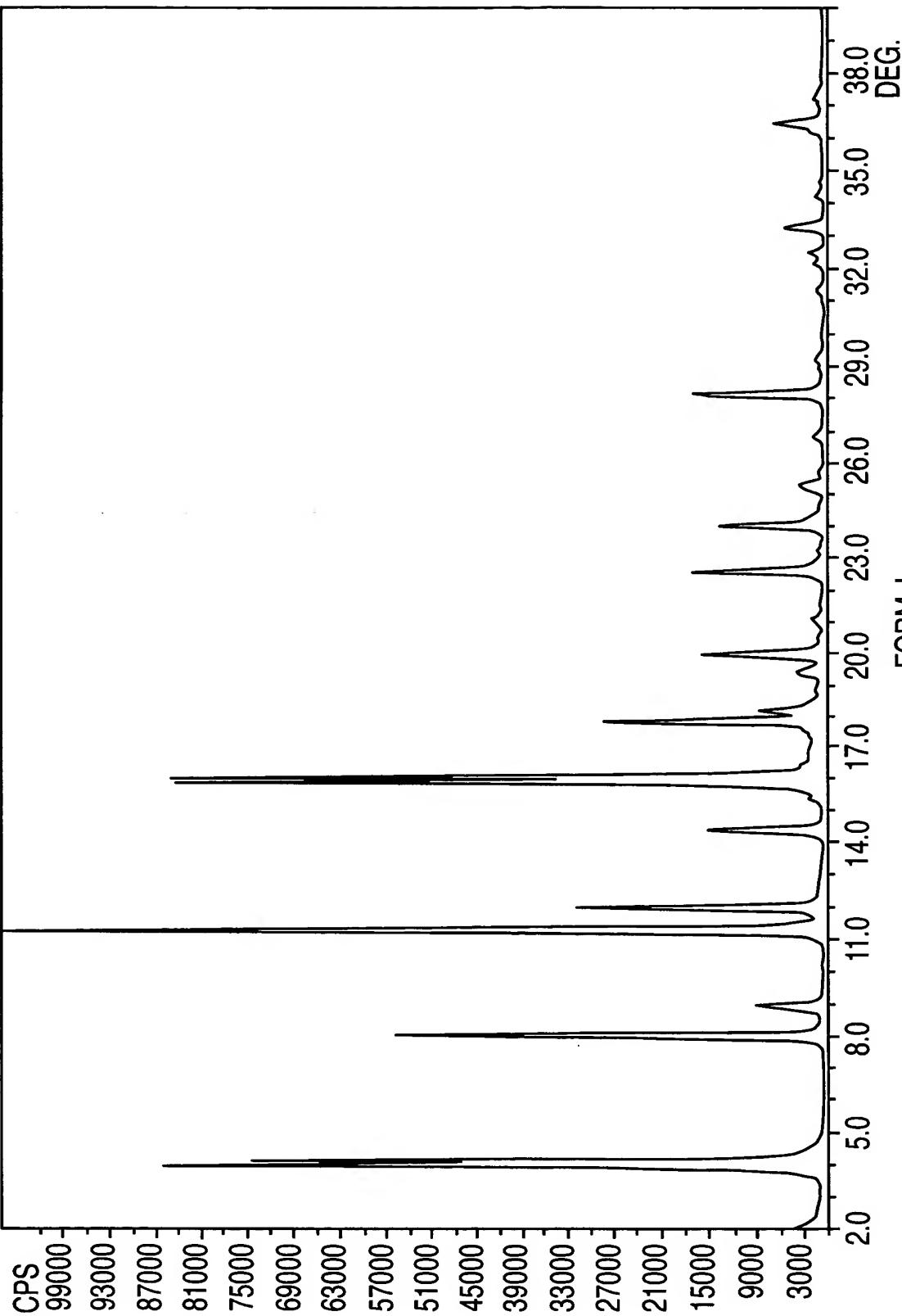


FIG. 6
FORM G

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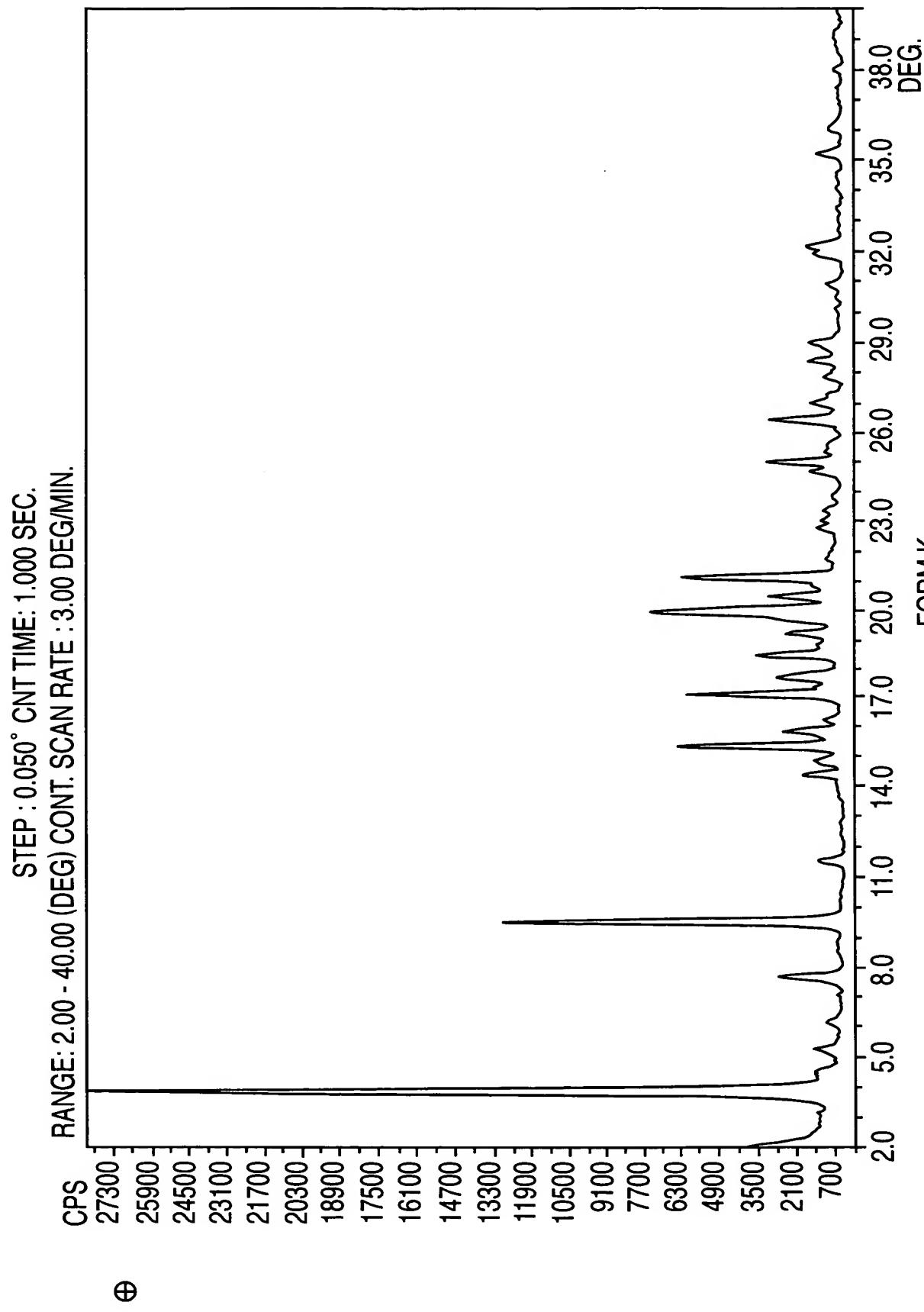


STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



⊕

FIG. 8
FORM J



STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

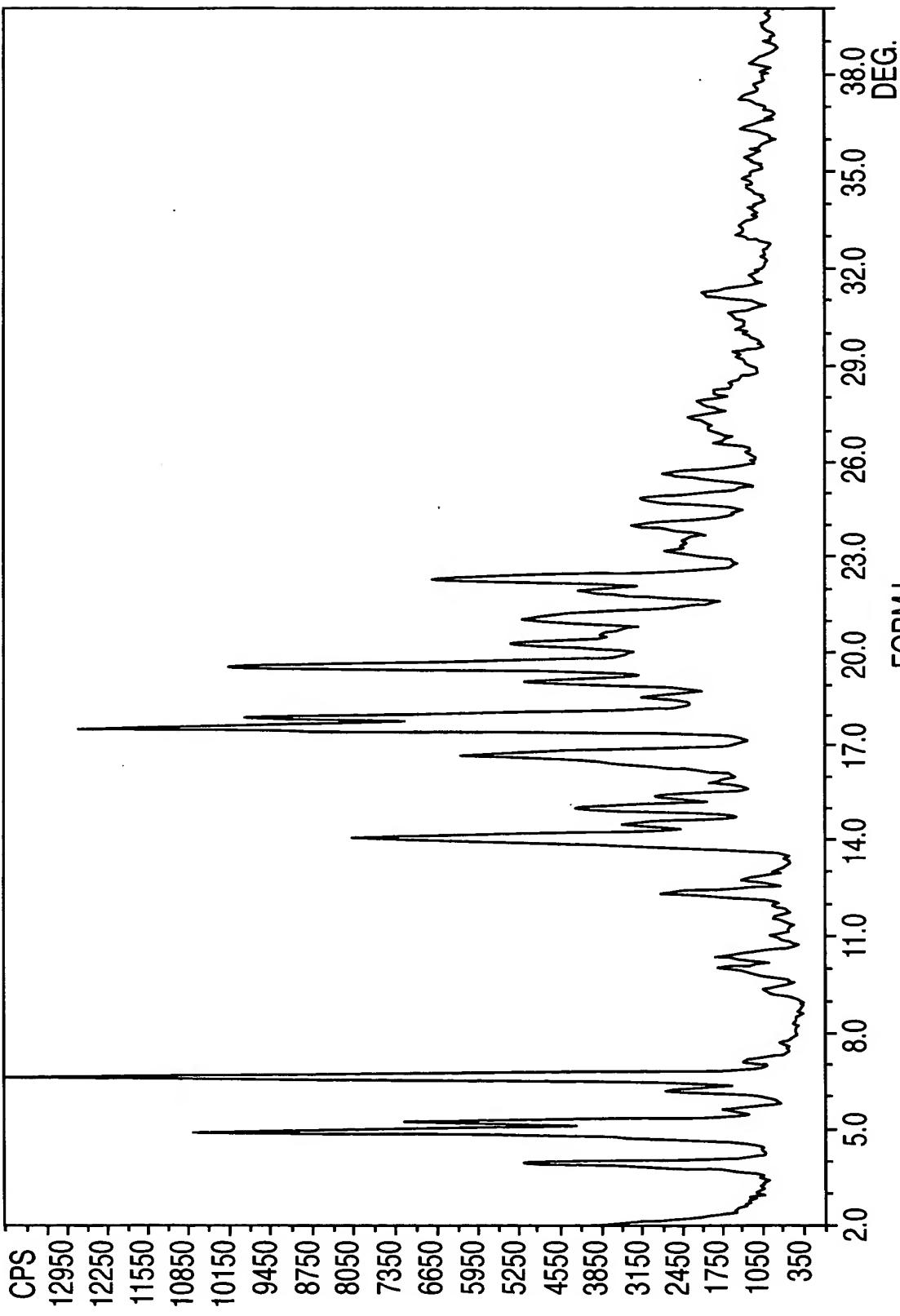


FIG. 10
FORM L

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

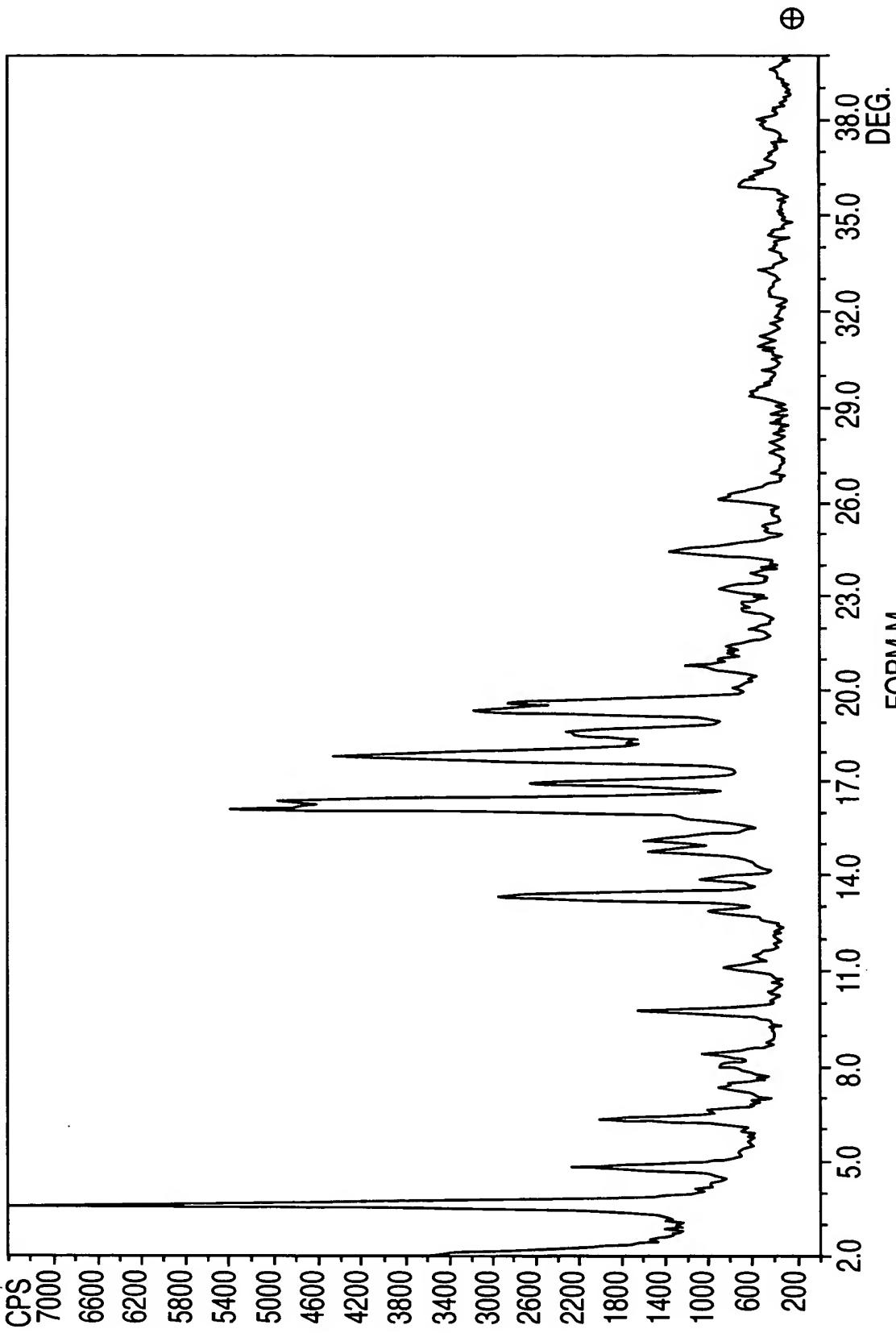


FIG. 11

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⊕

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

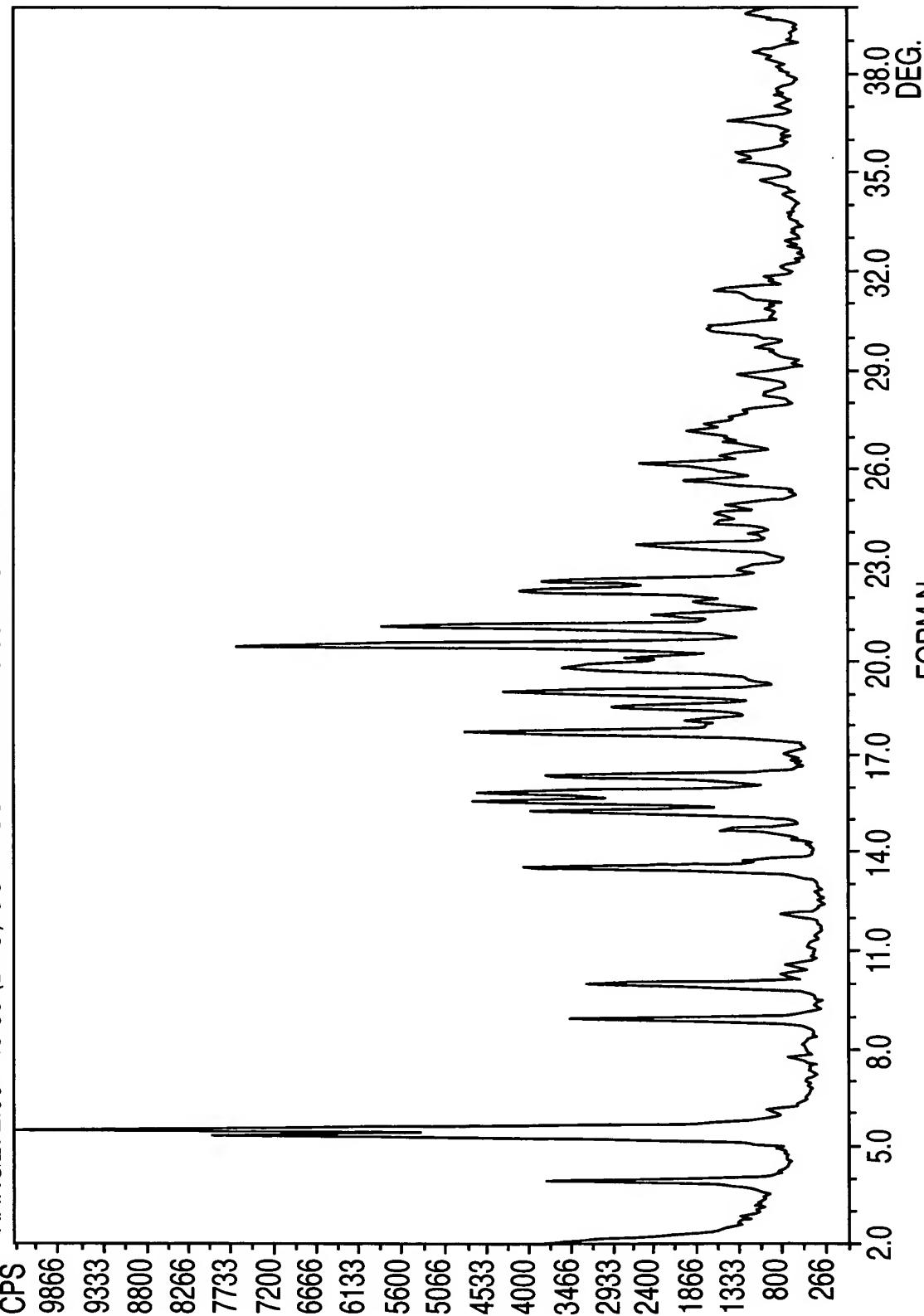


FIG. 12
FORM N

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⊗

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

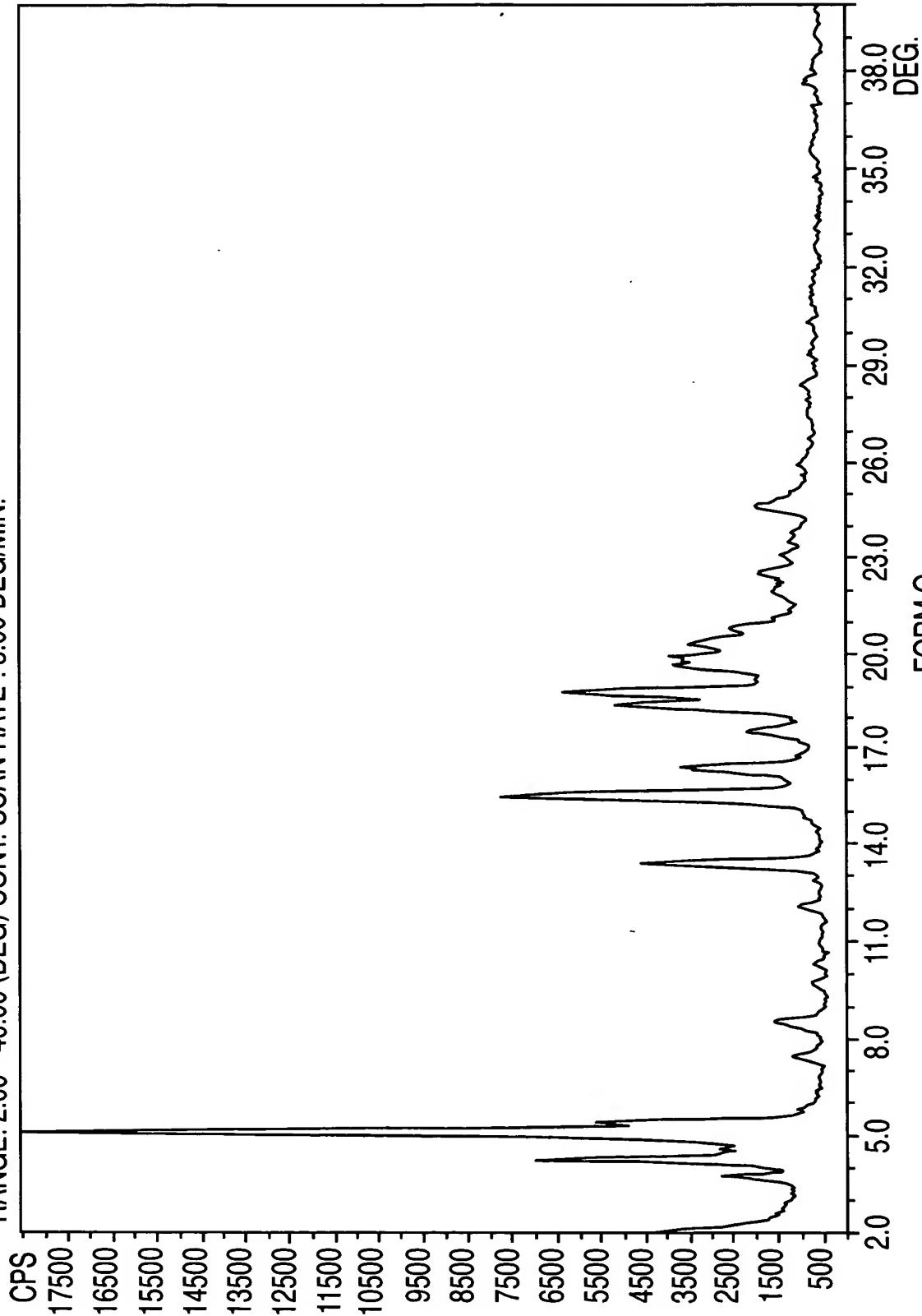


FIG. 13
FORM O

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

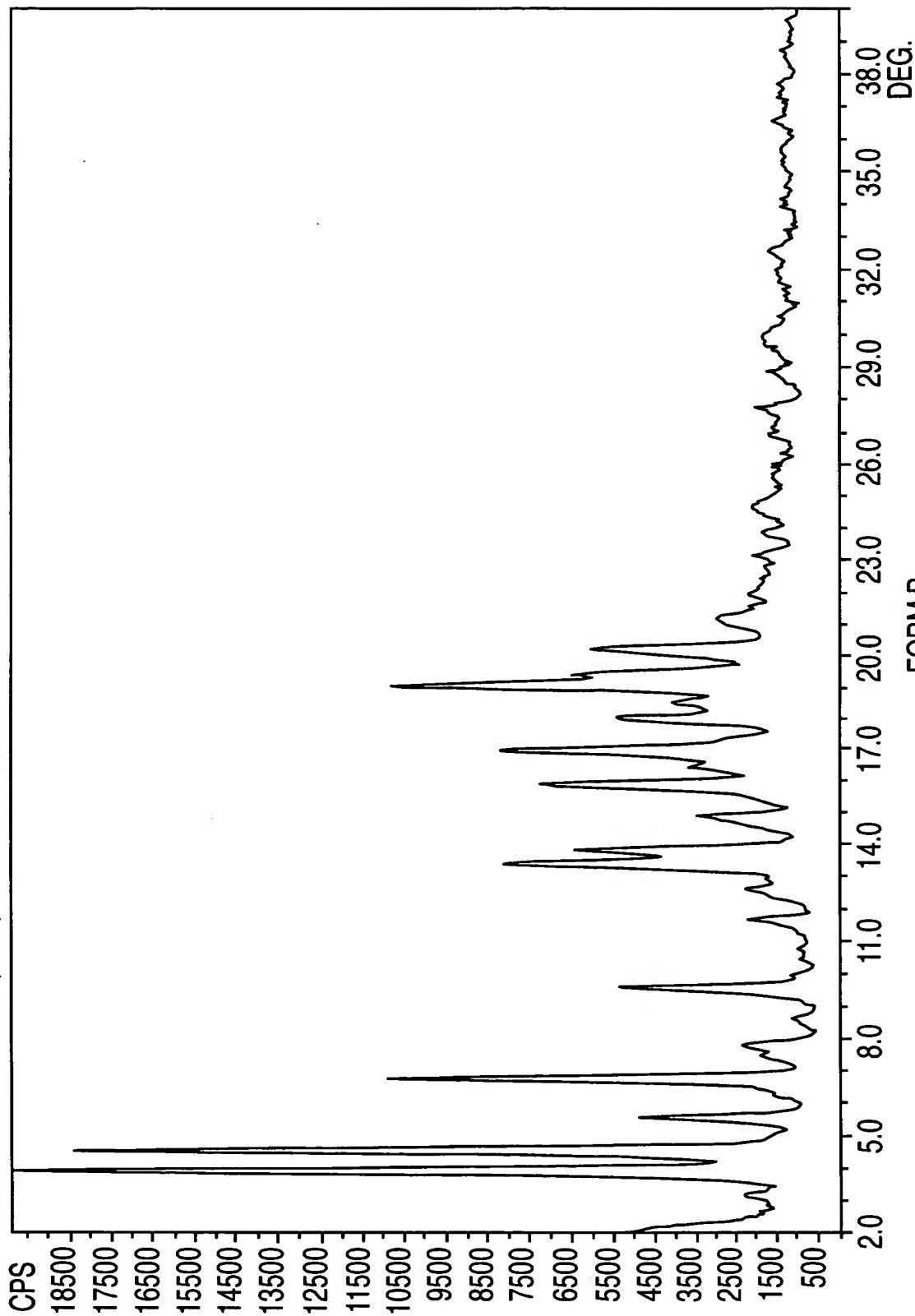


FIG. 14
FORM P

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⊗

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

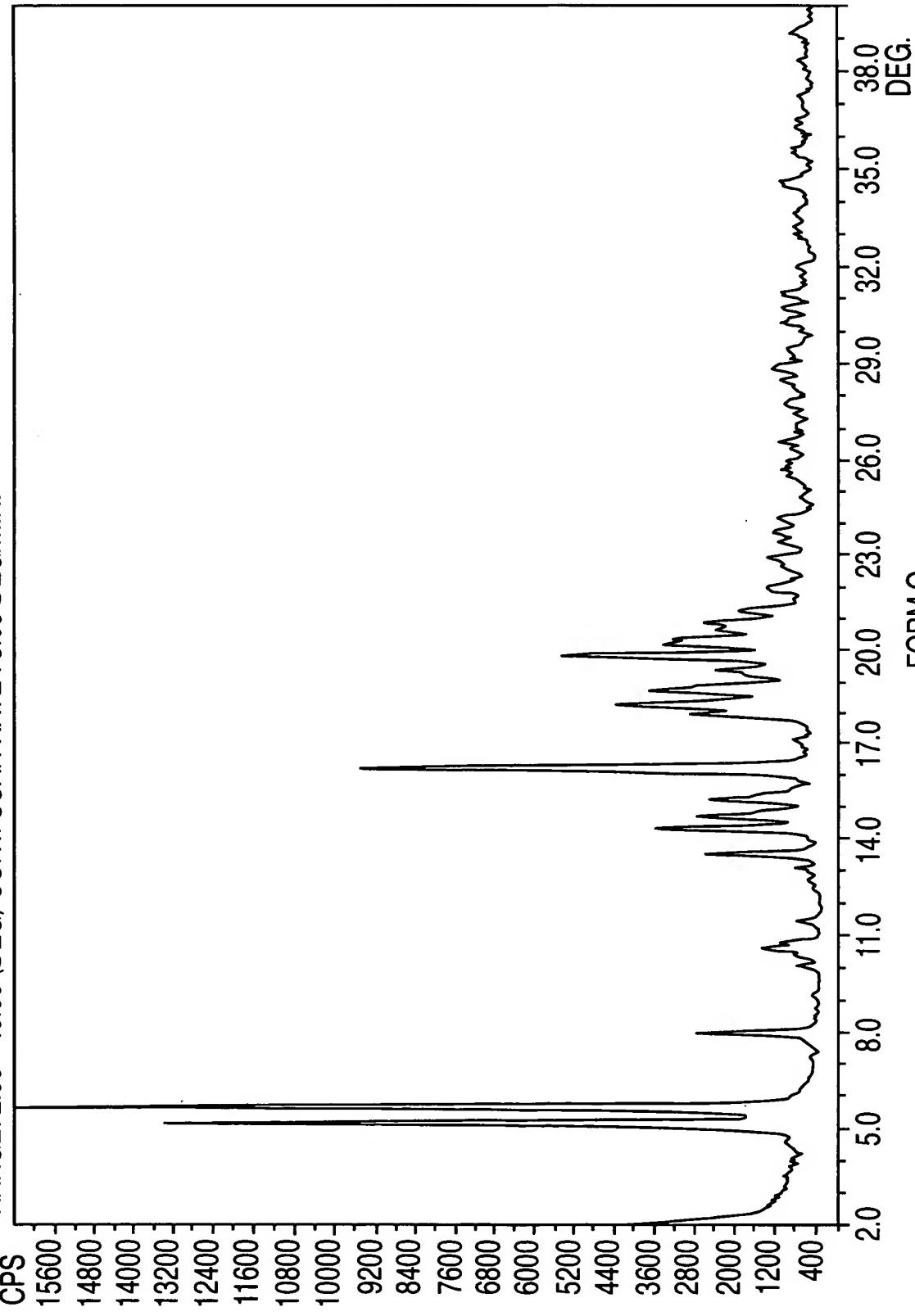


FIG. 15

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⊕

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

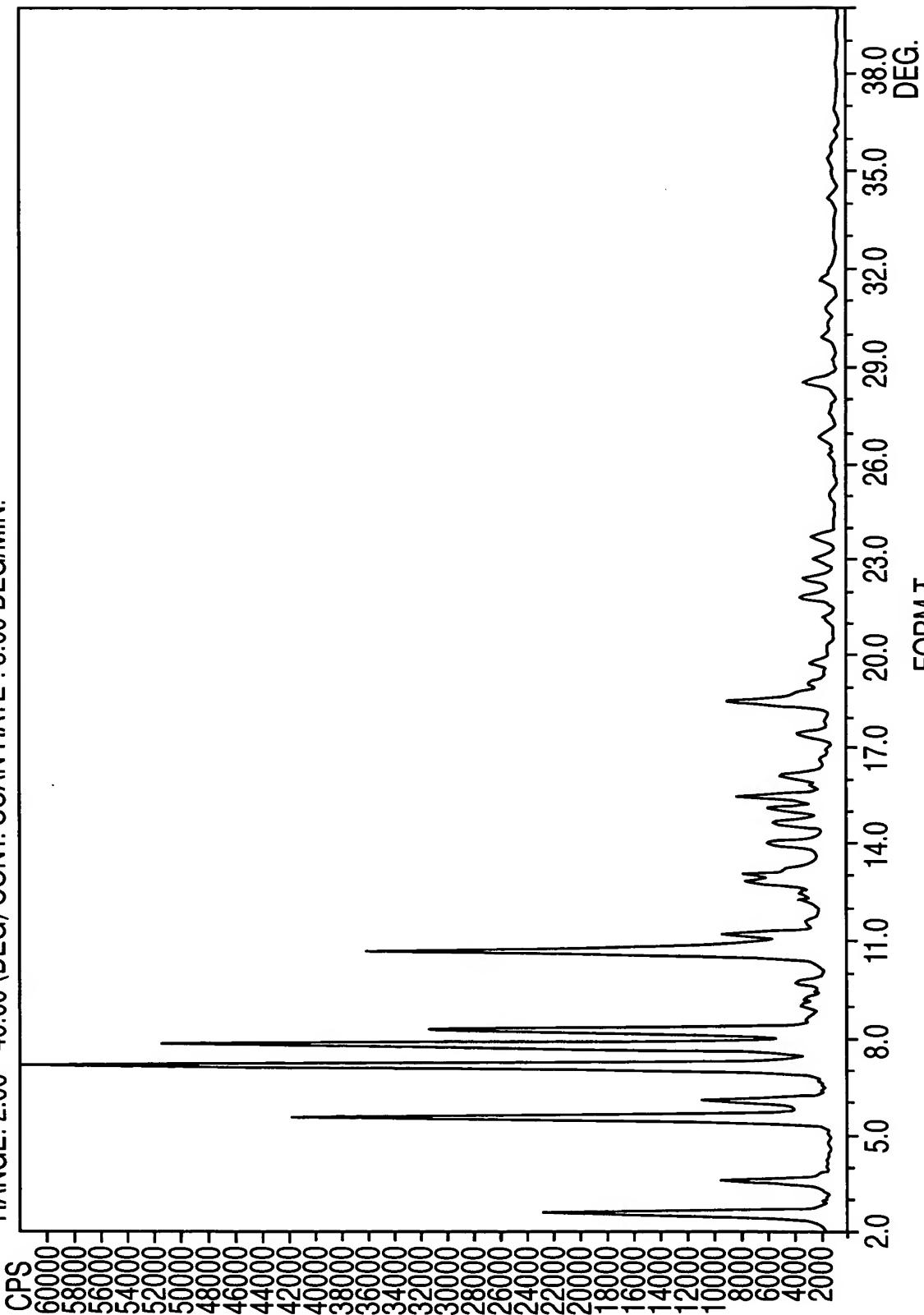


FIG. 16
FORM T

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

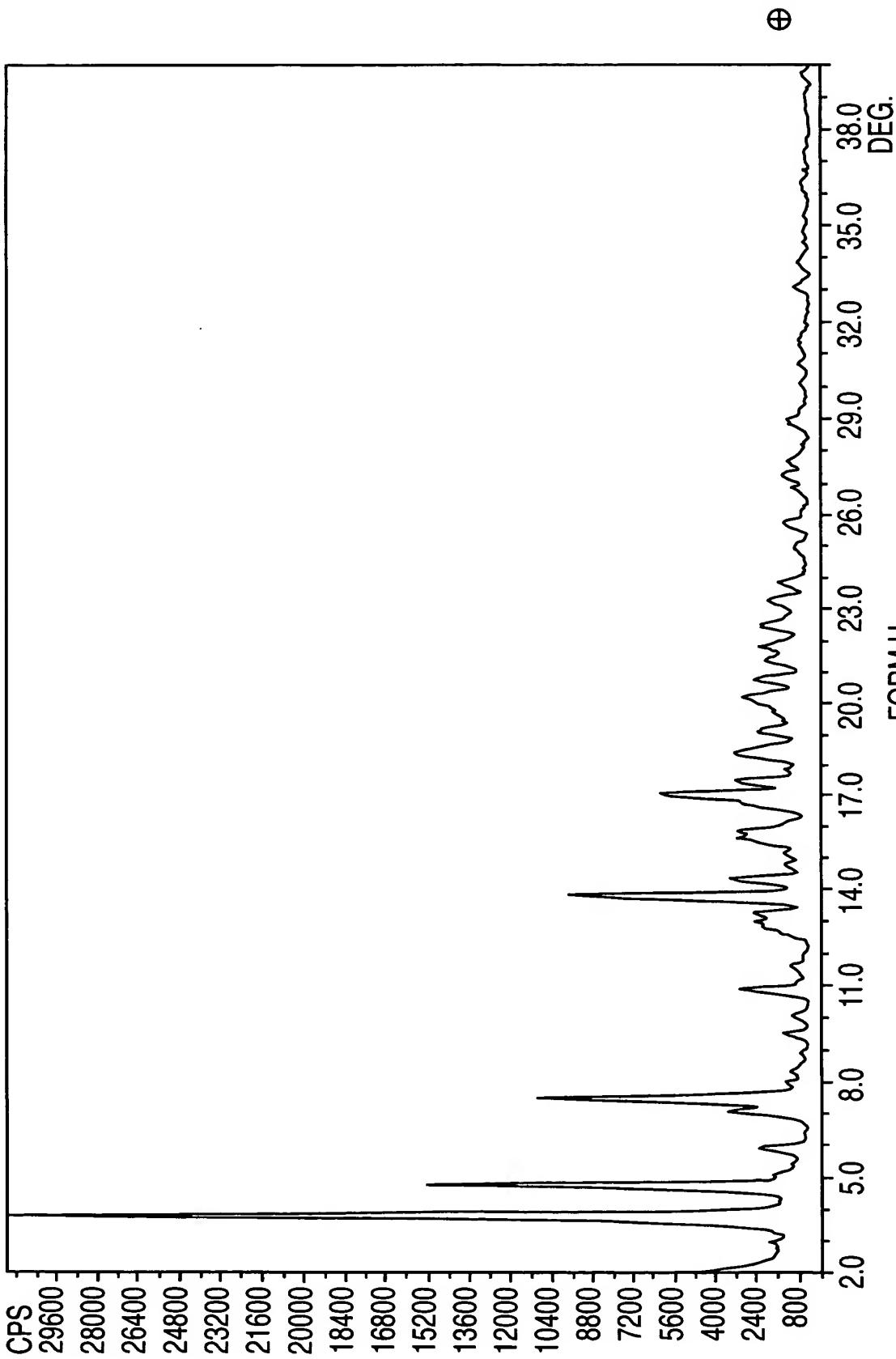


FIG. 17
FORM U

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⊕

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CNT. SCAN RATE : 3.00 DEG/MIN.

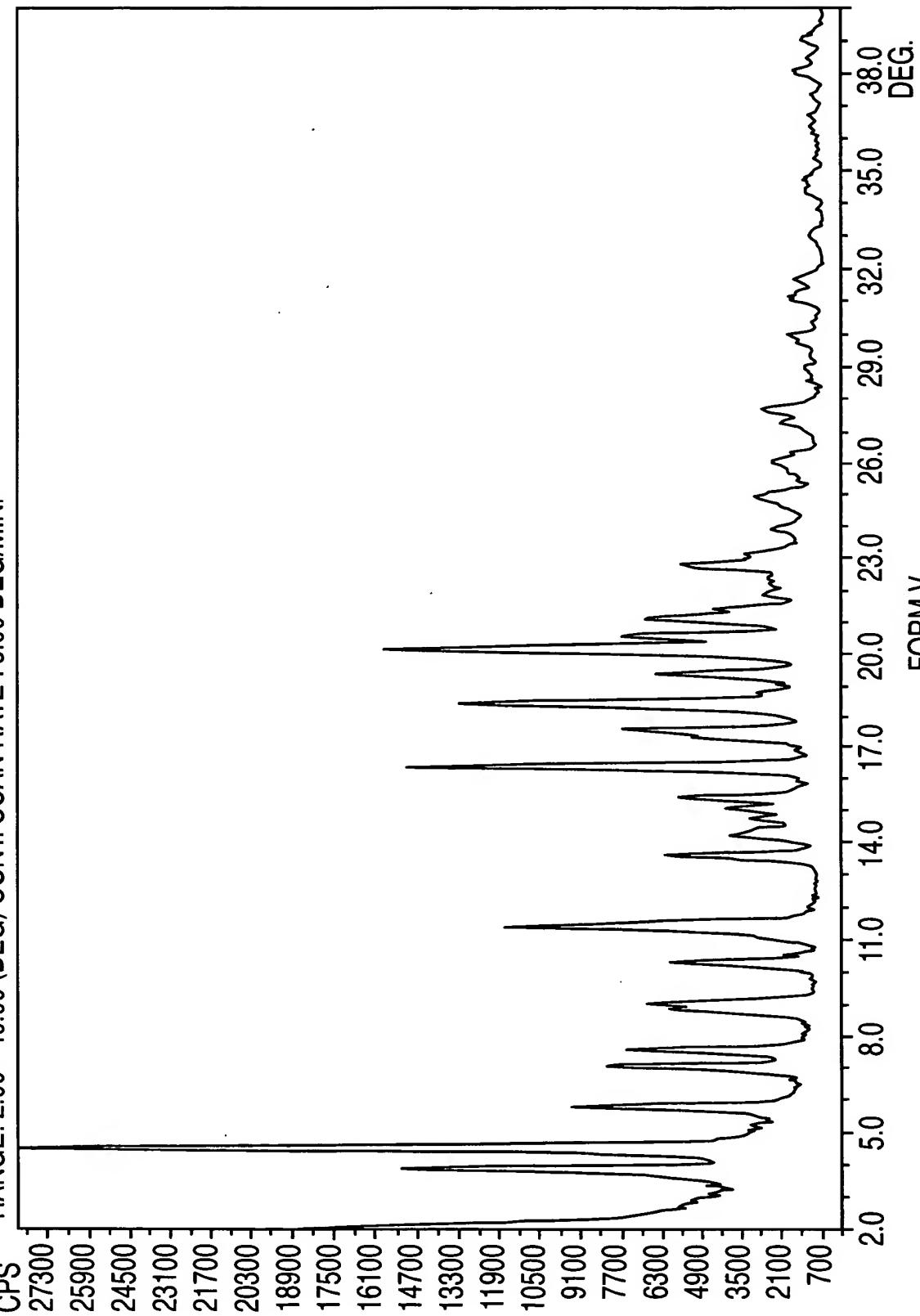


FIG. 18
FORM V

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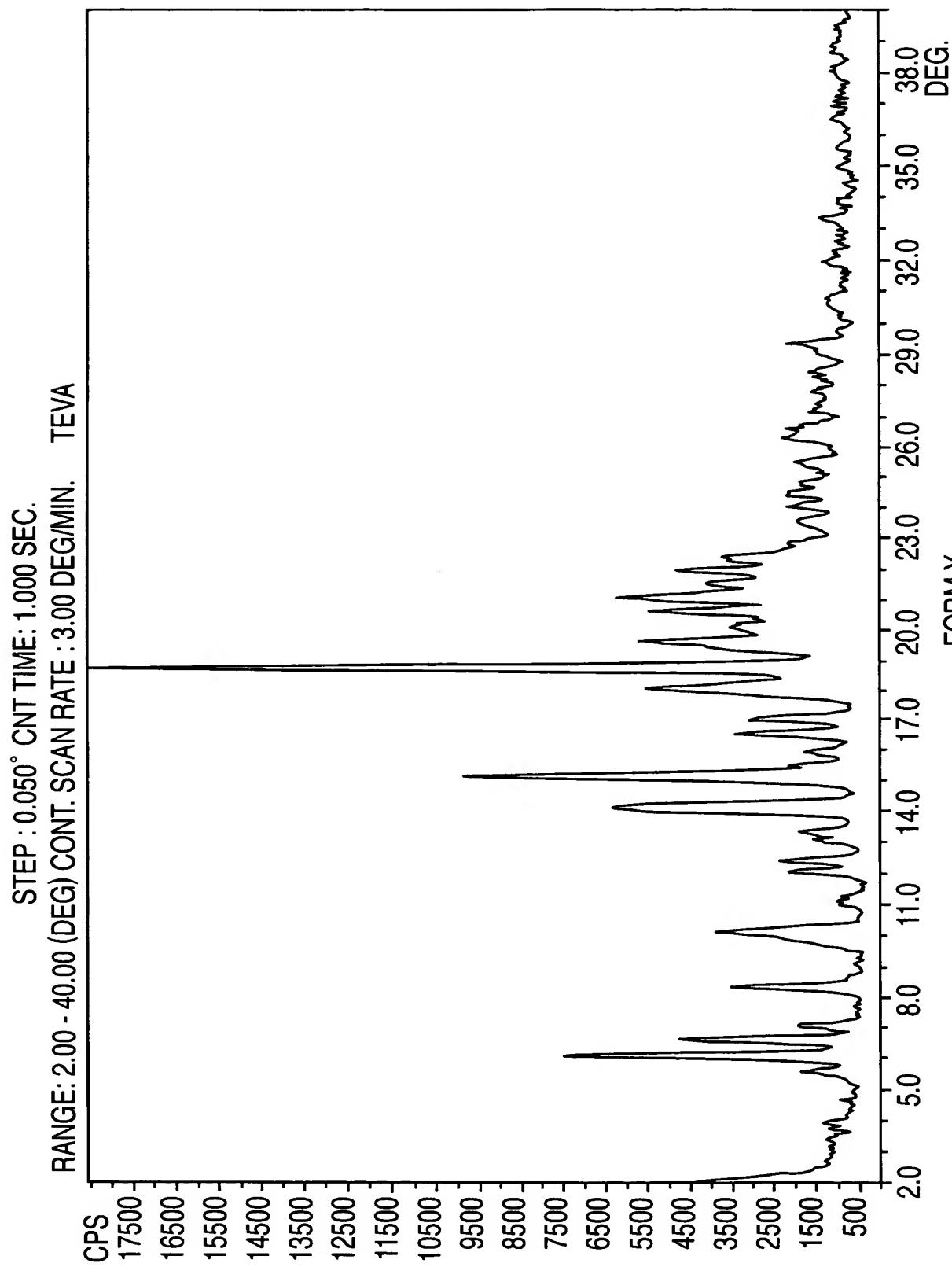
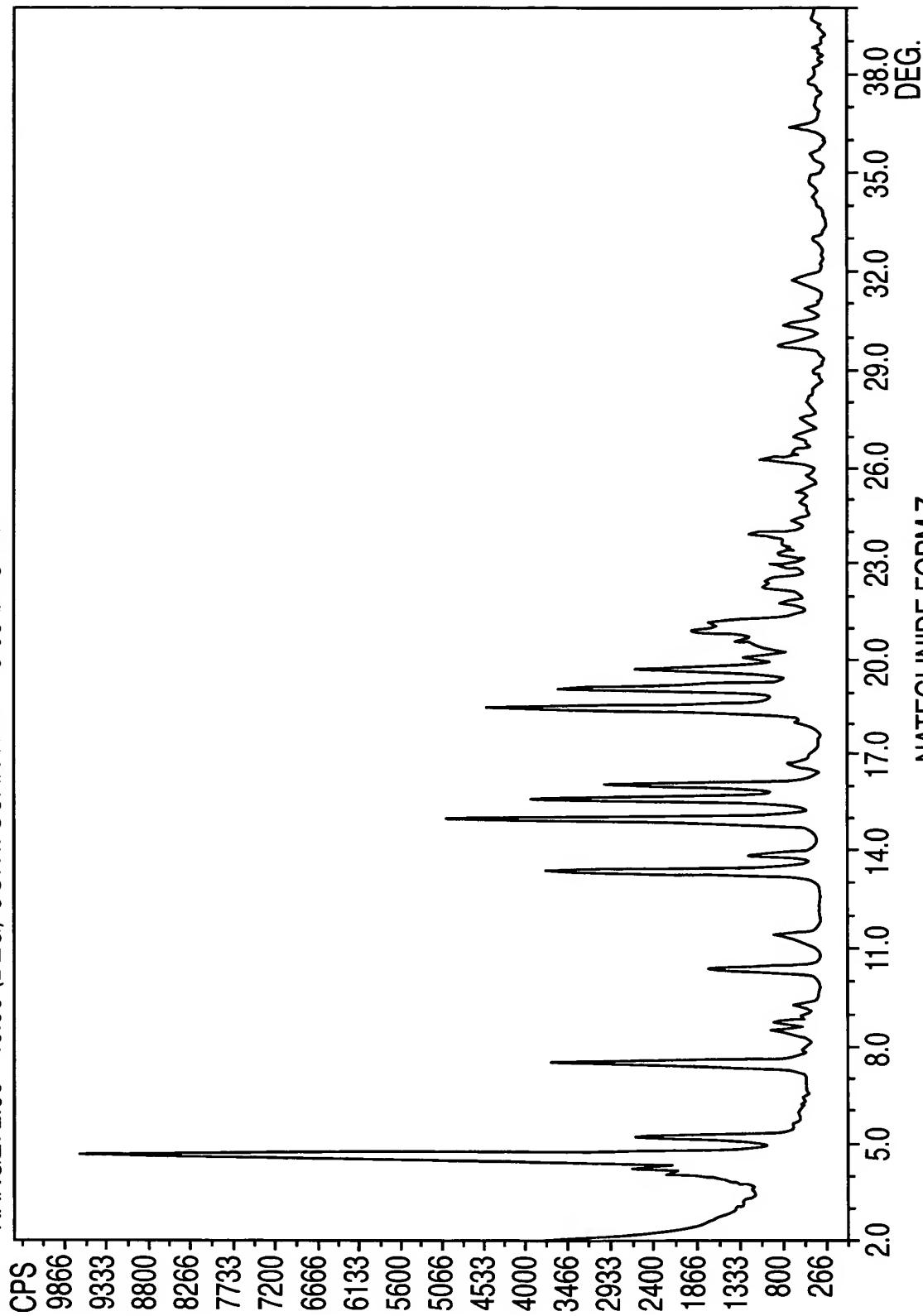


FIG. 19

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



NATEGLINIDE FORM Z
FIG. 20

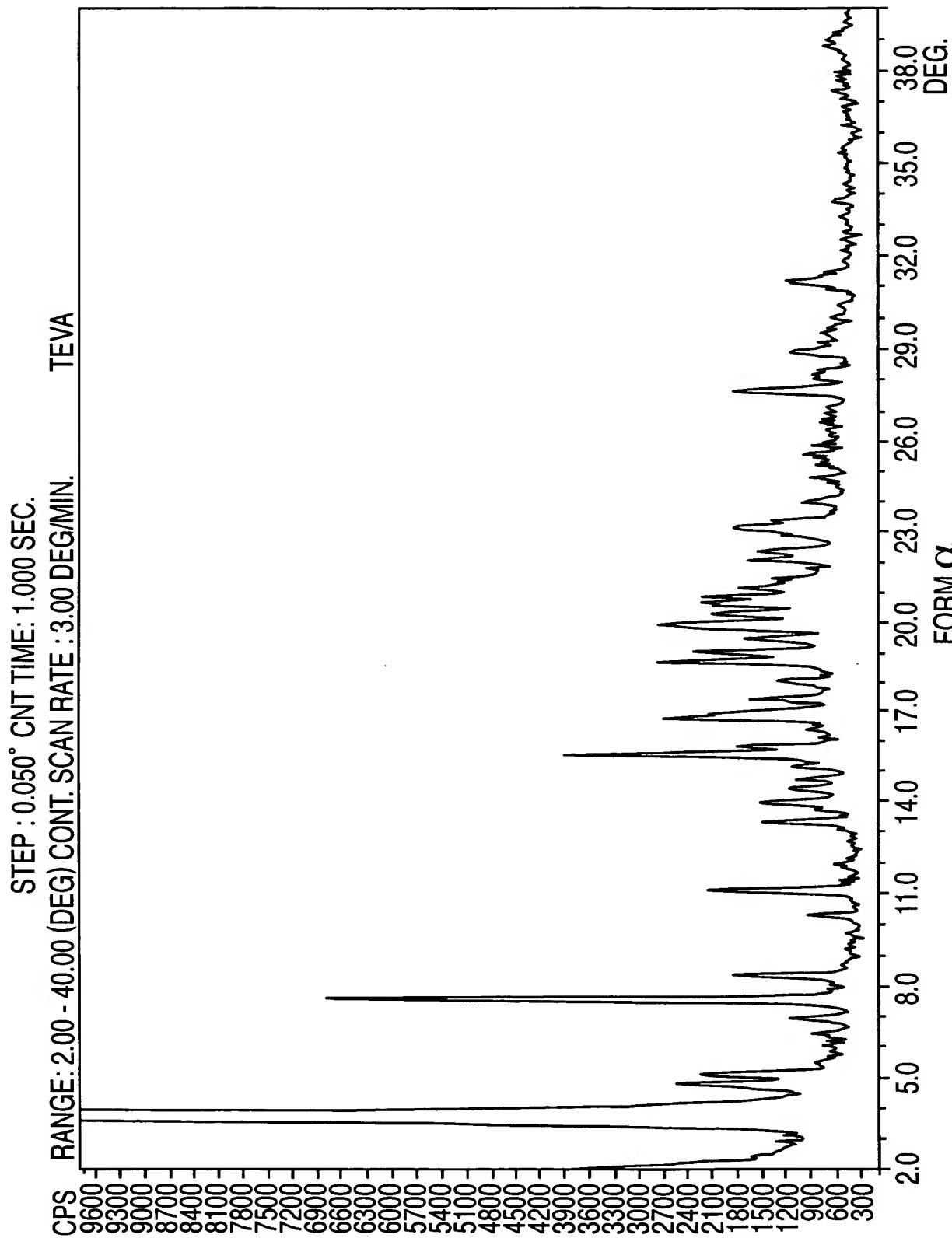


FIG. 21

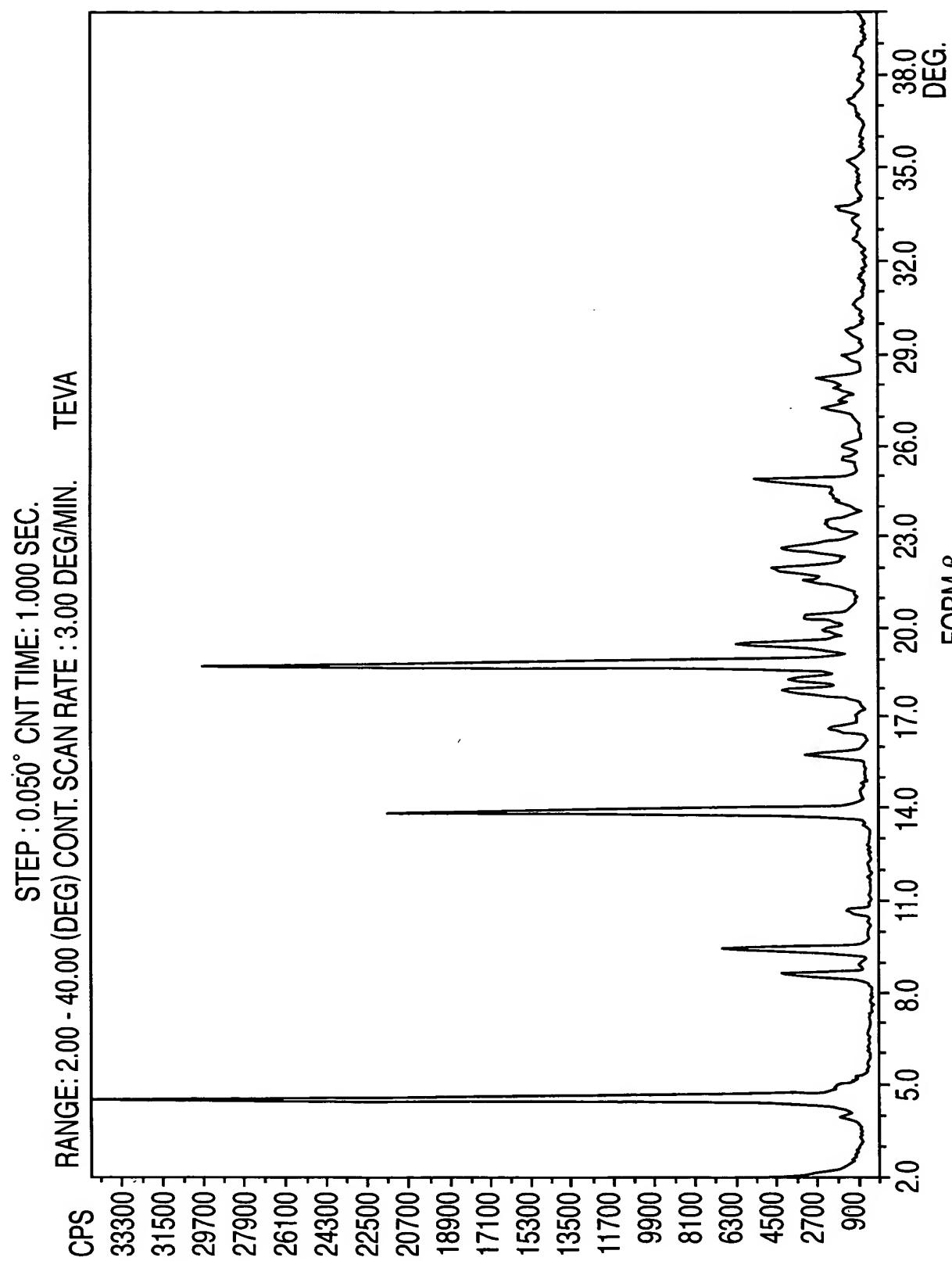


FIG. 22

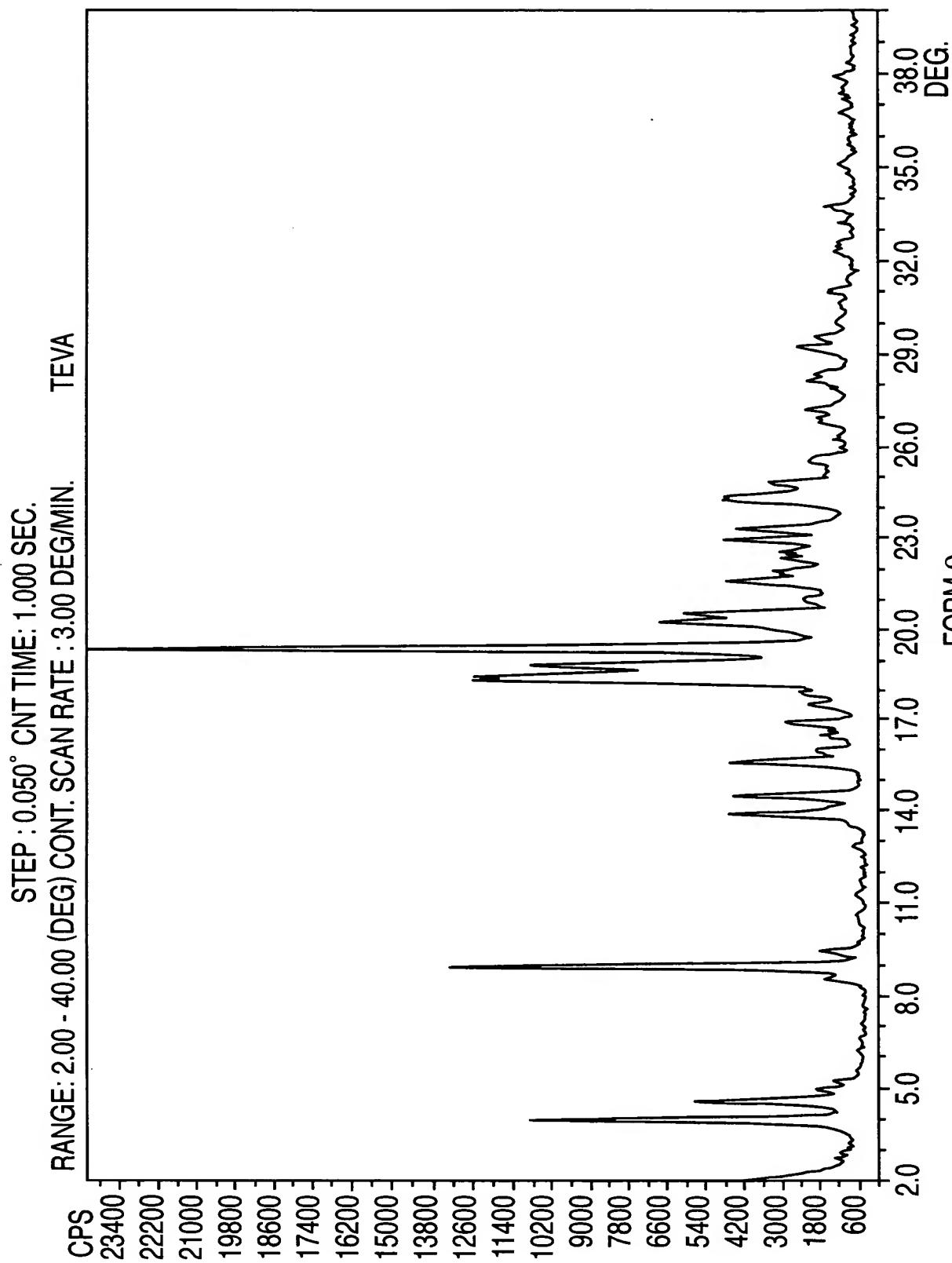


FIG. 23

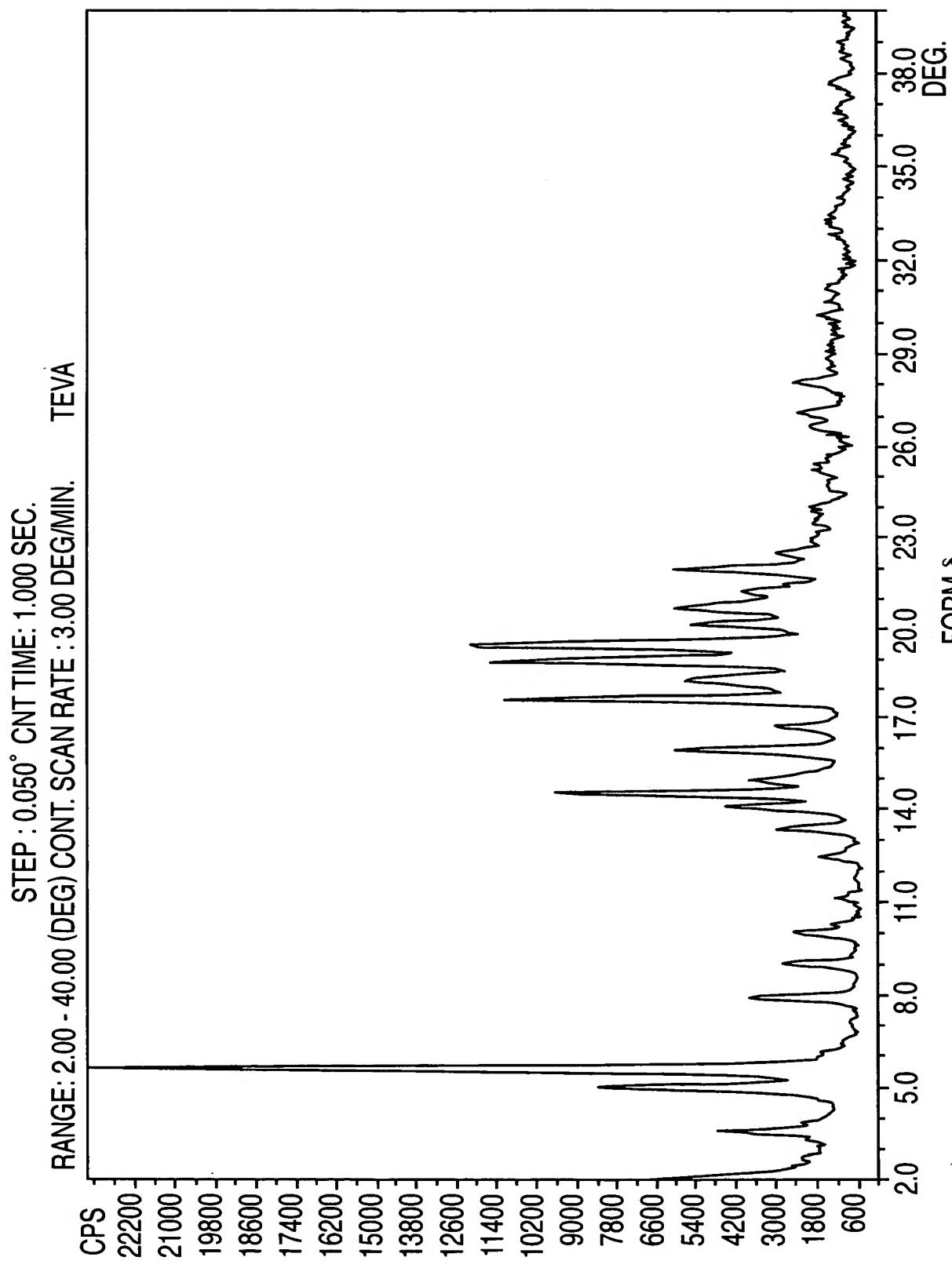
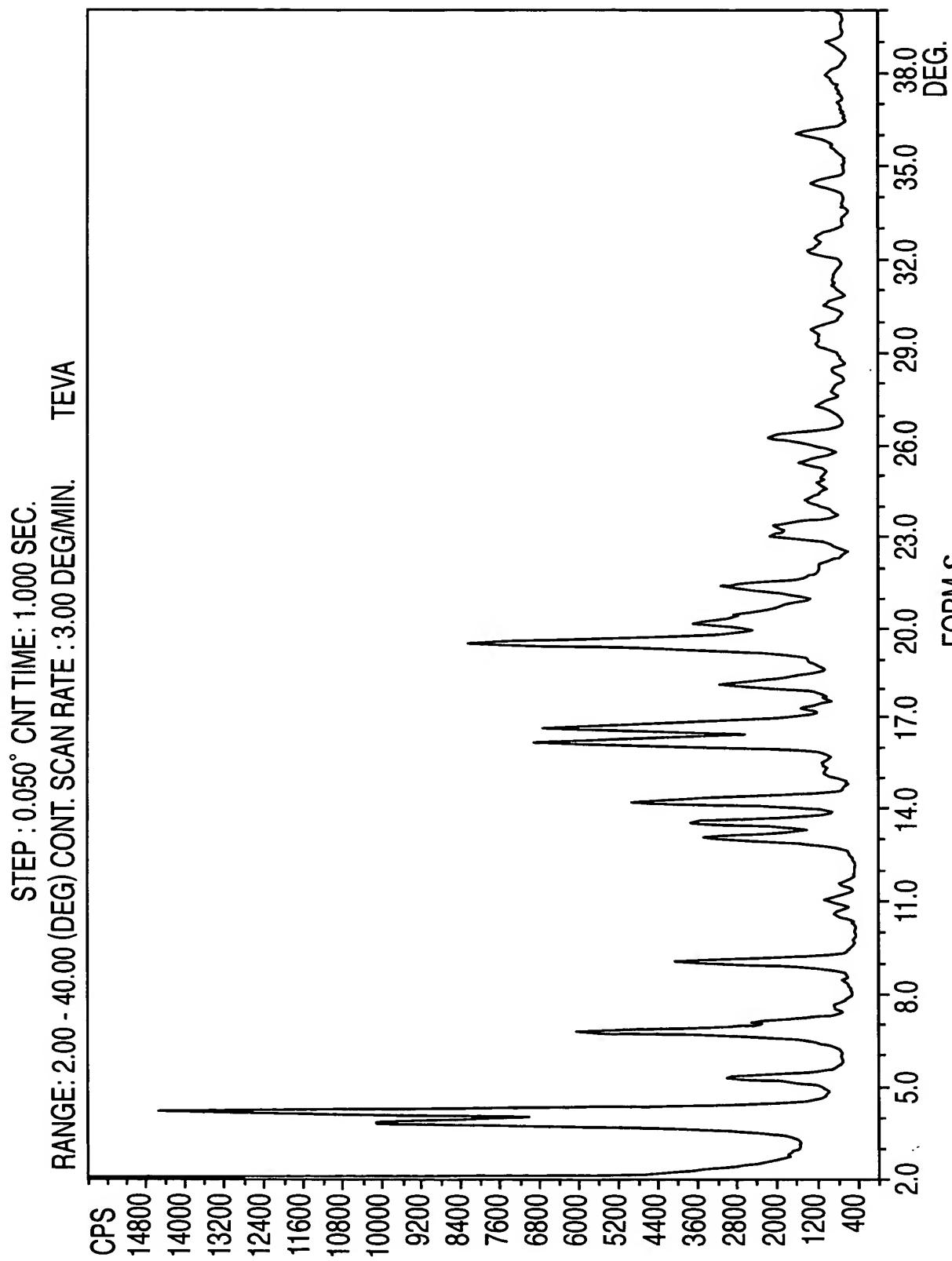


FIG. 24

FIG. 25
FORM ϵ

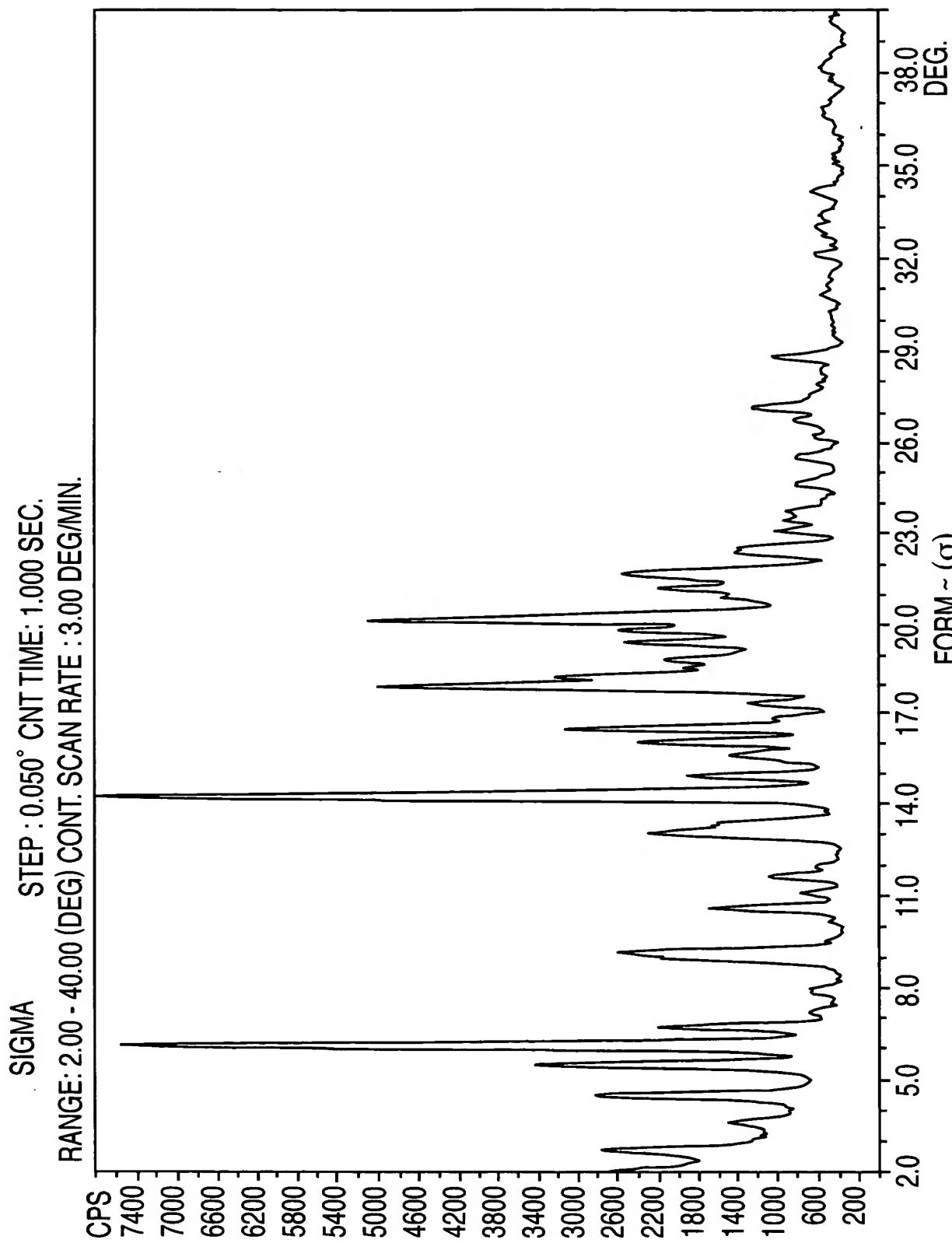


FIG. 26

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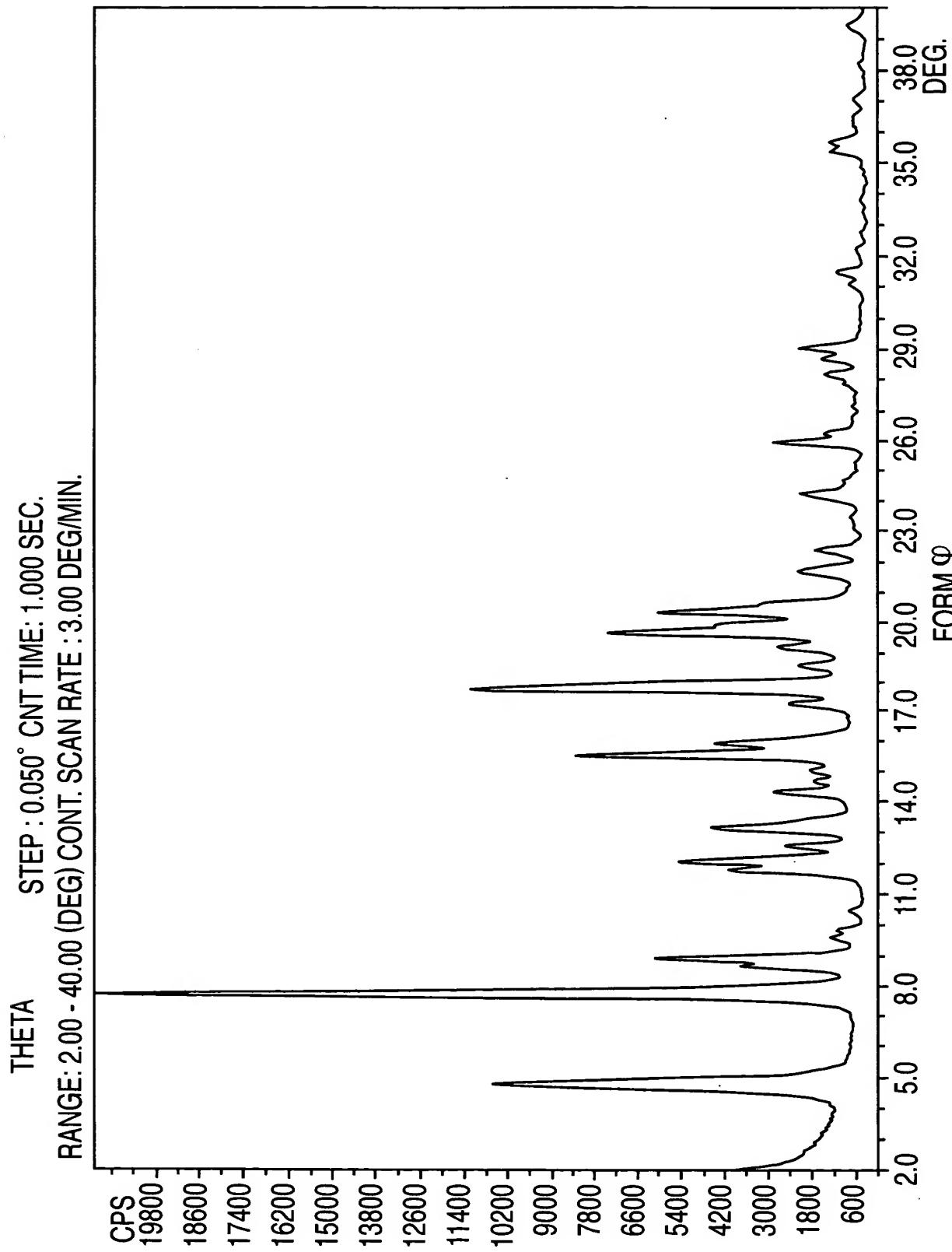
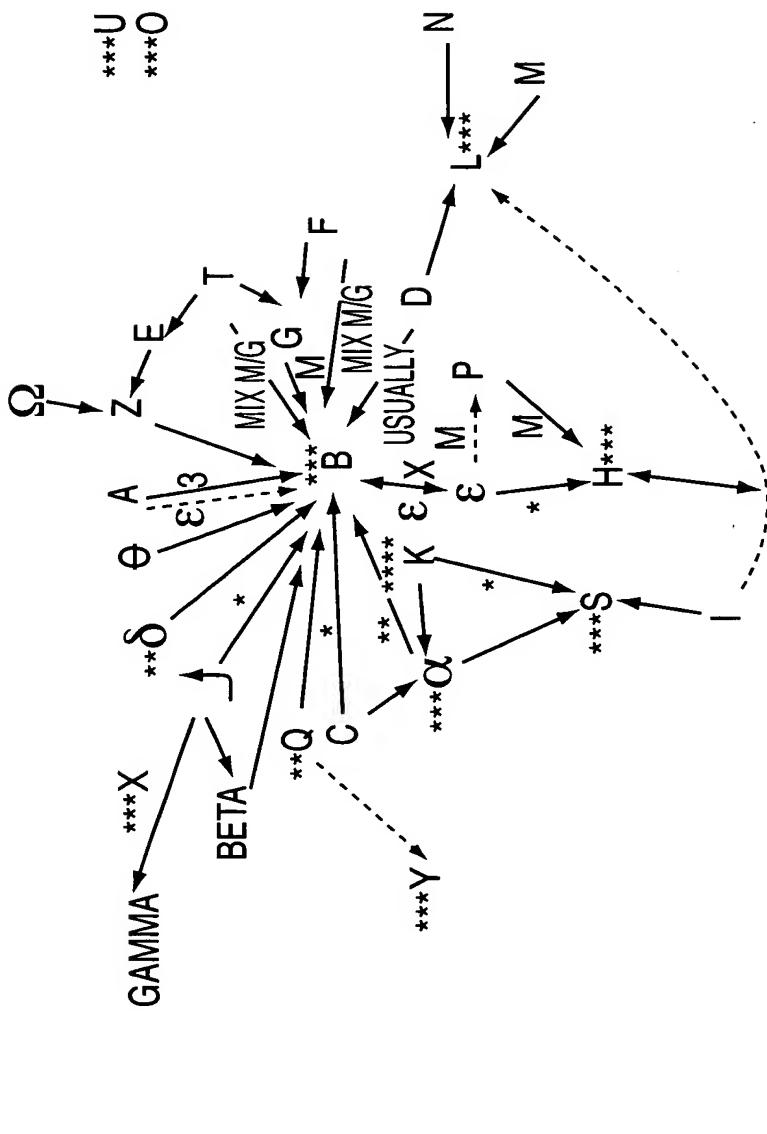


FIG. 27



- * TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.
- ** THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).
- *** THERMALLY STABLE FORMS.
- TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.
- m MIXTURE WITH STARTING FORM.
- **** WHEN STARTING MATERIAL CONTAINS SEEDS.
- sol RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

THERMAL STABILITY CHART
FIG. 28

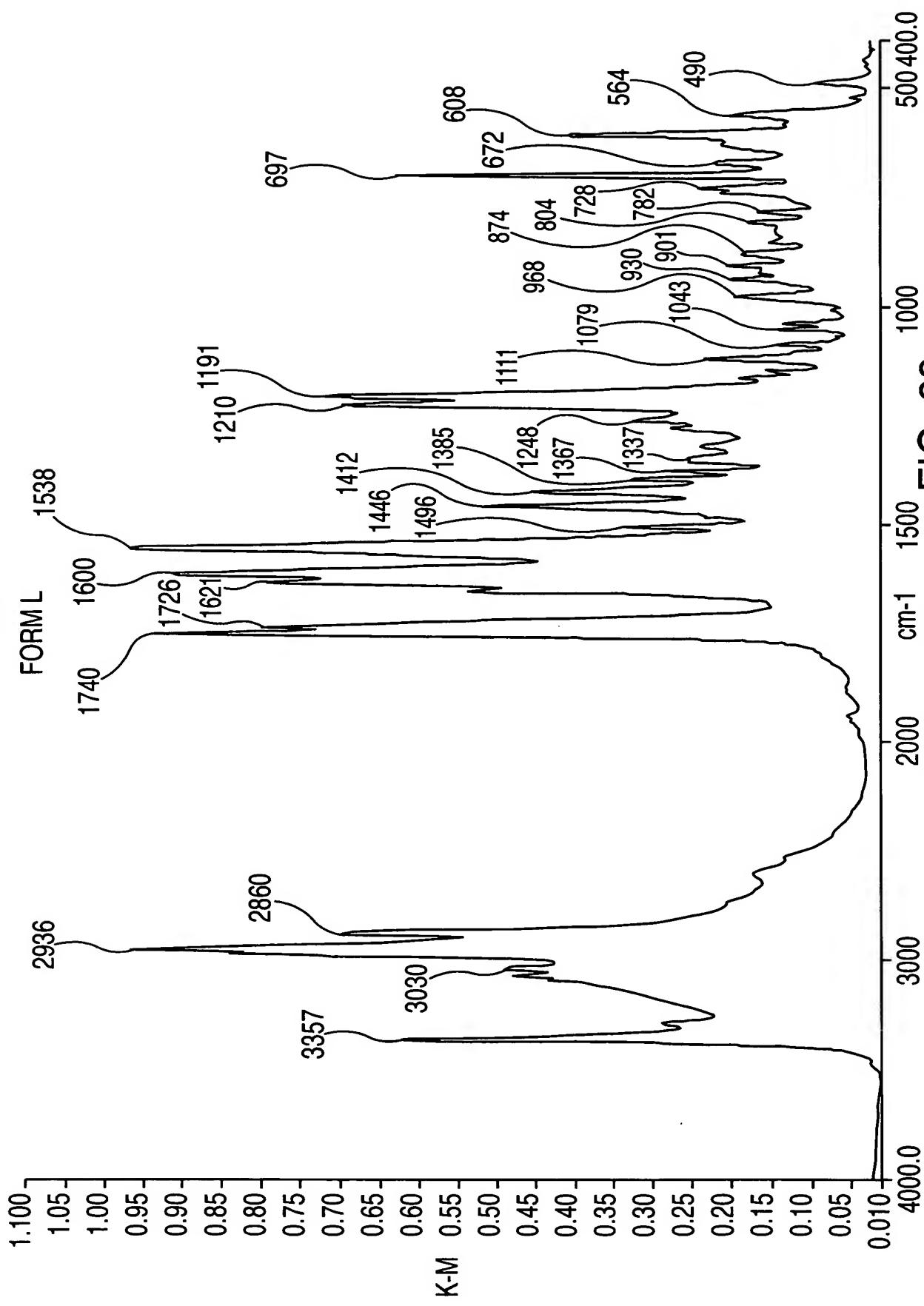
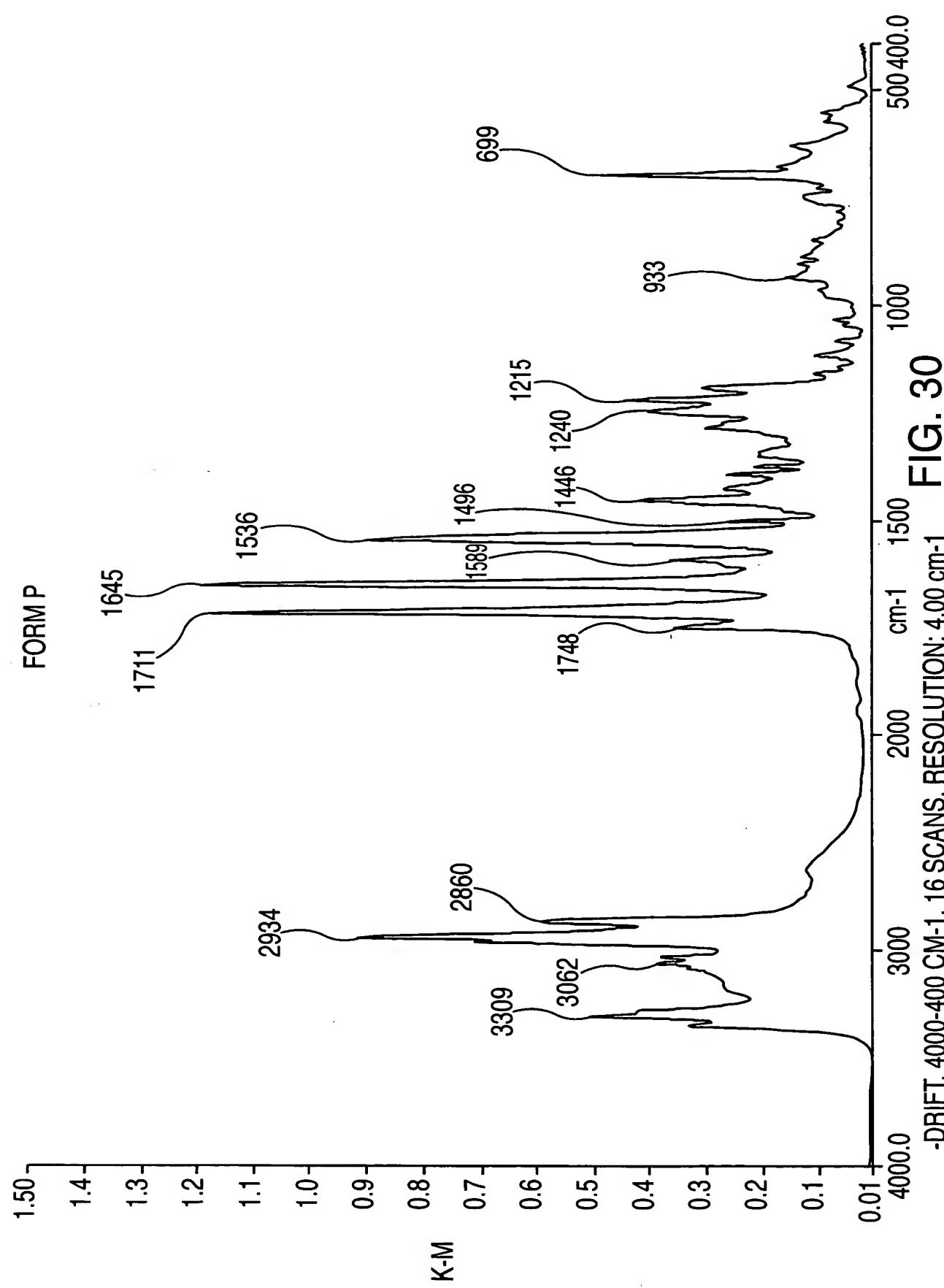
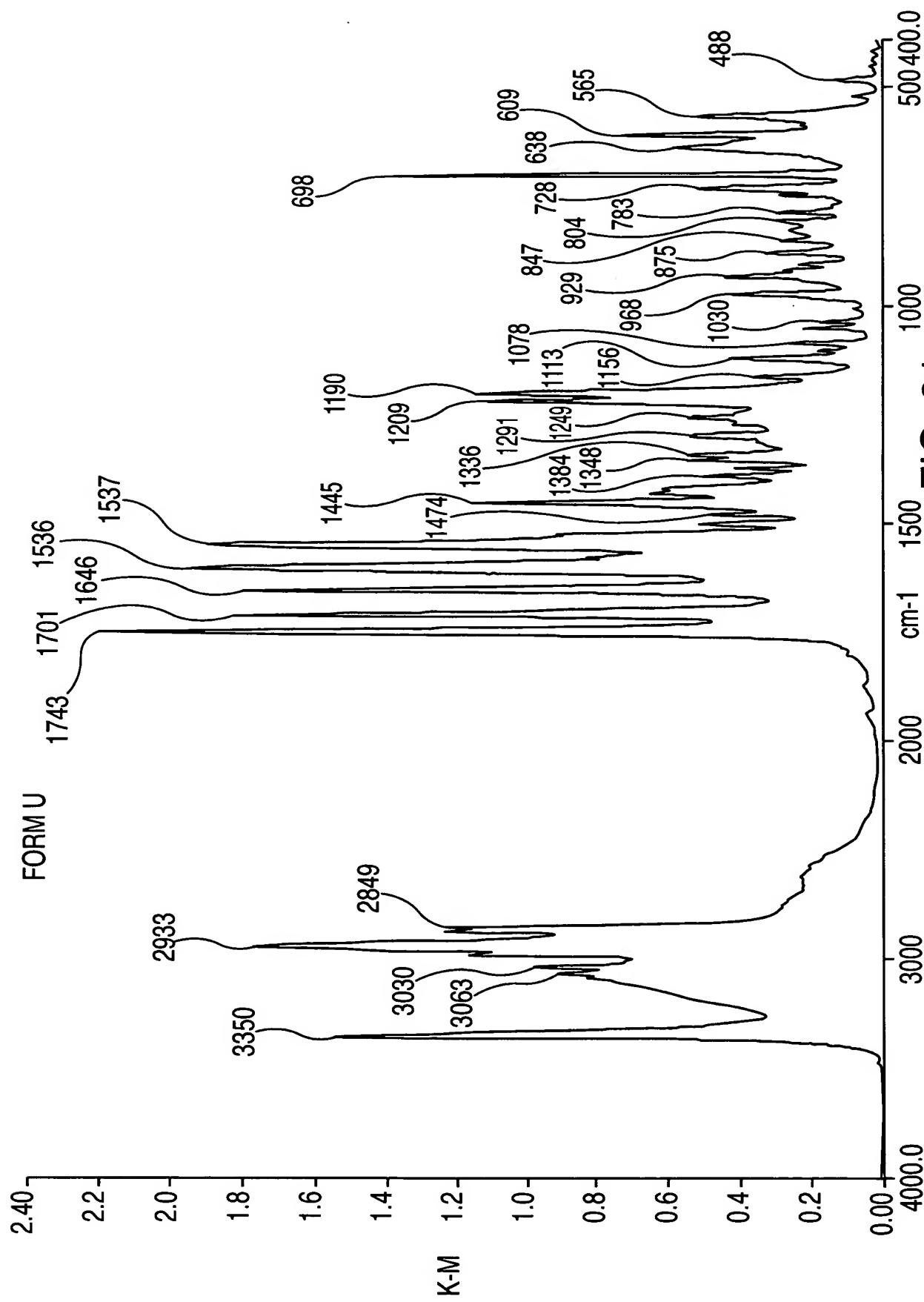


FIG. 29
-DRIFT, 4000-400 CM^{-1} , 16 SCANS, RESOLUTION: 4.00 cm^{-1}

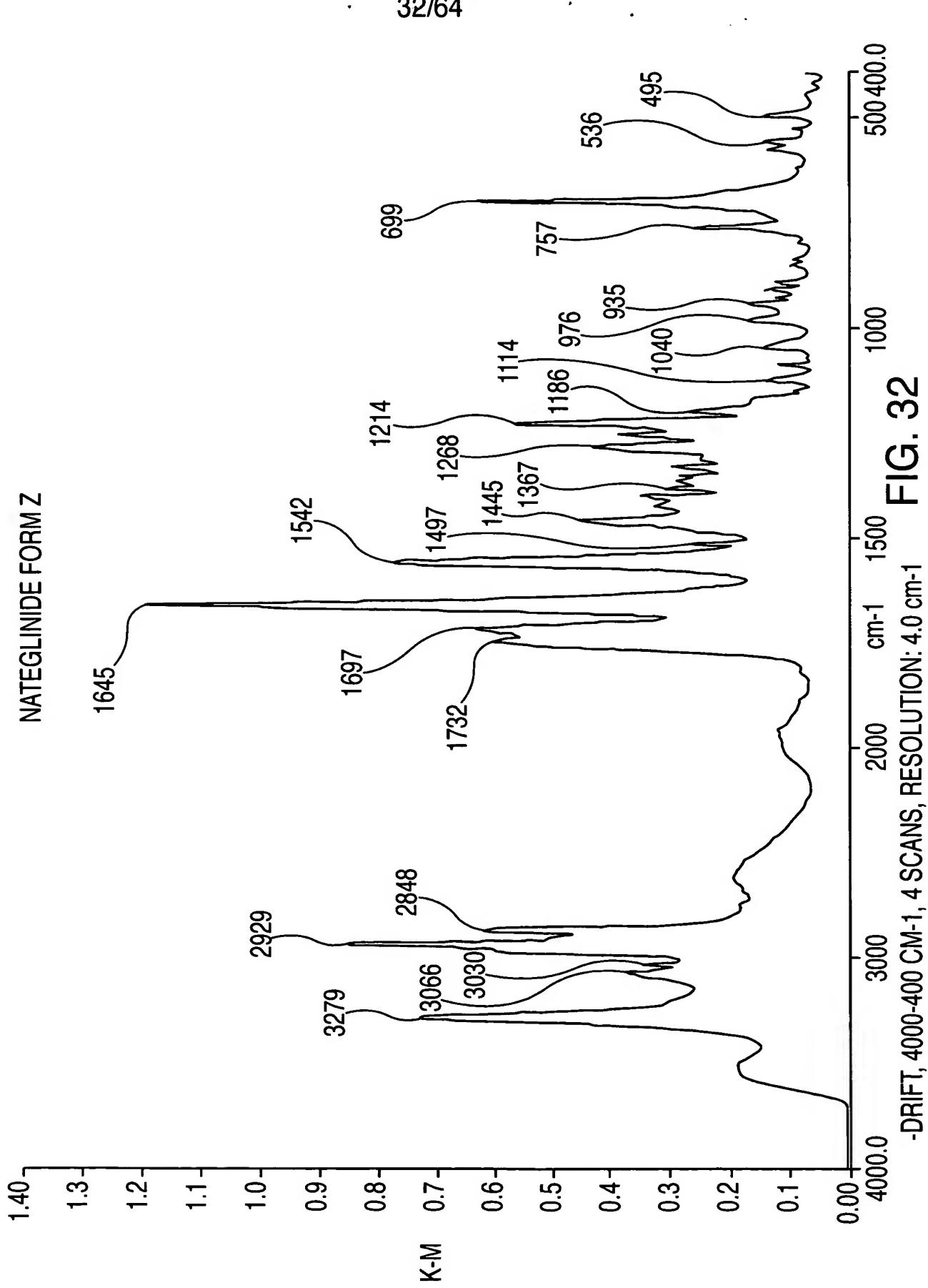
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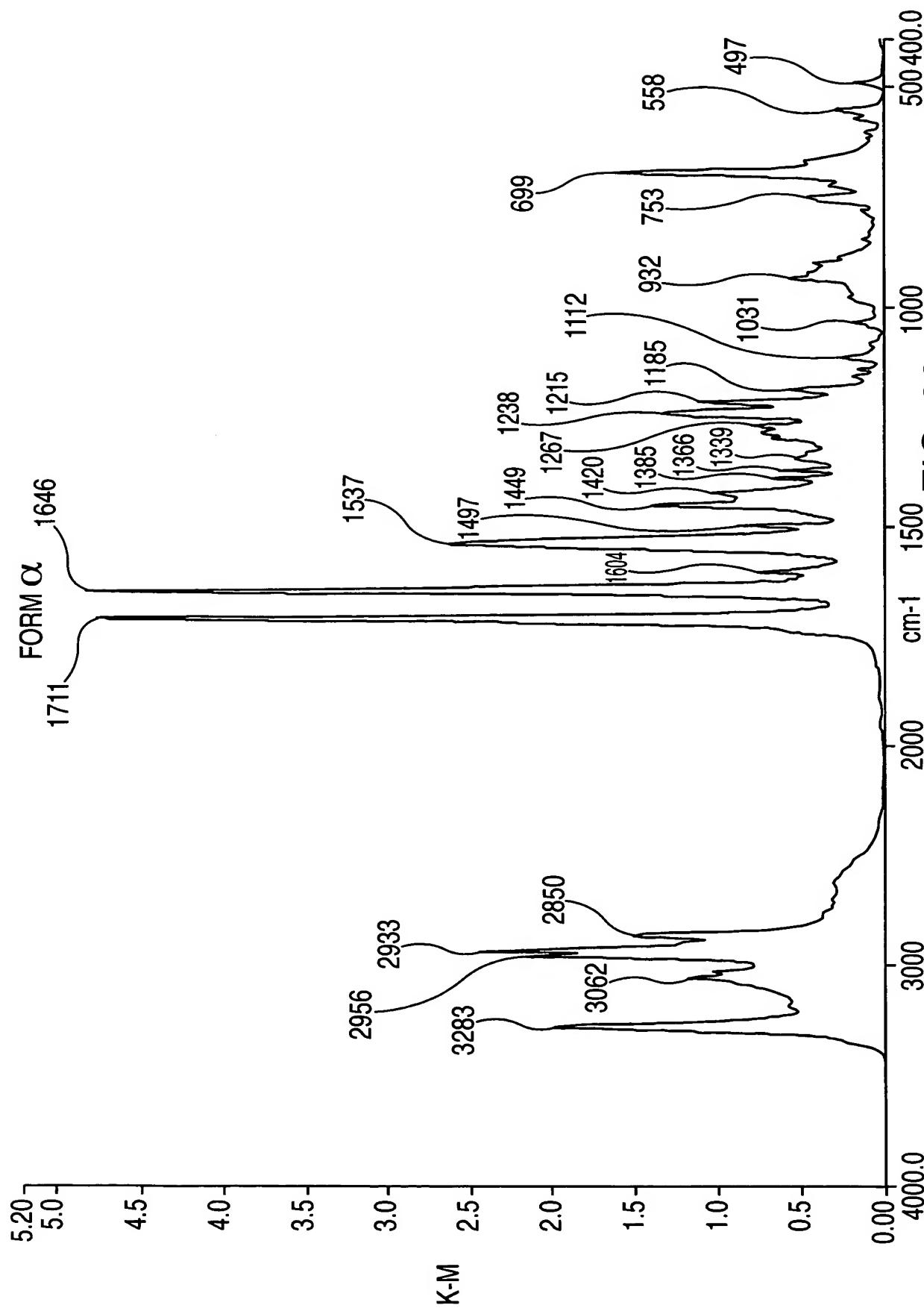


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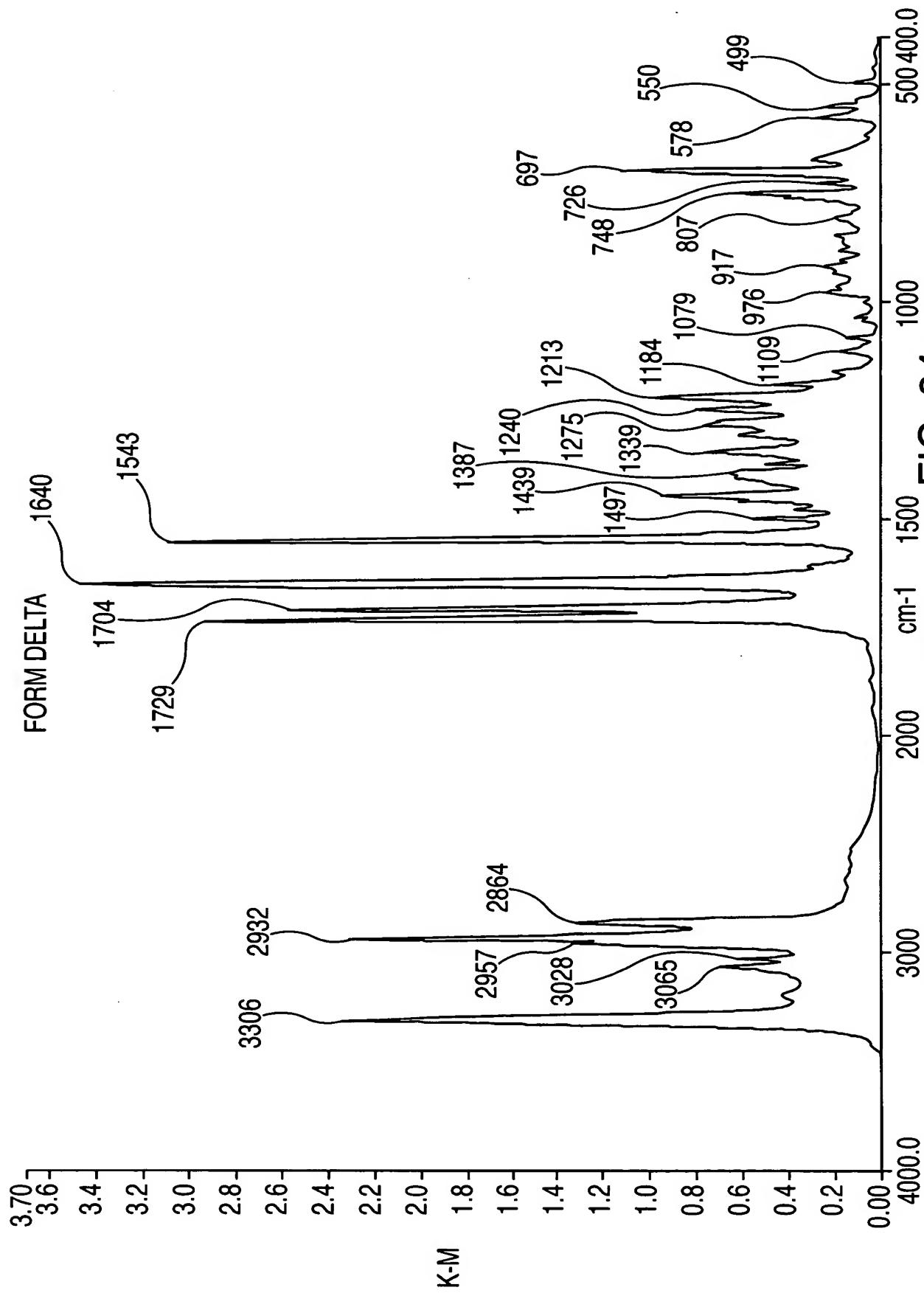


-DRIFT, 4000-400 CM^{-1} , 16 SCANS, RESOLUTION: 4.0 cm^{-1} FIG. 31

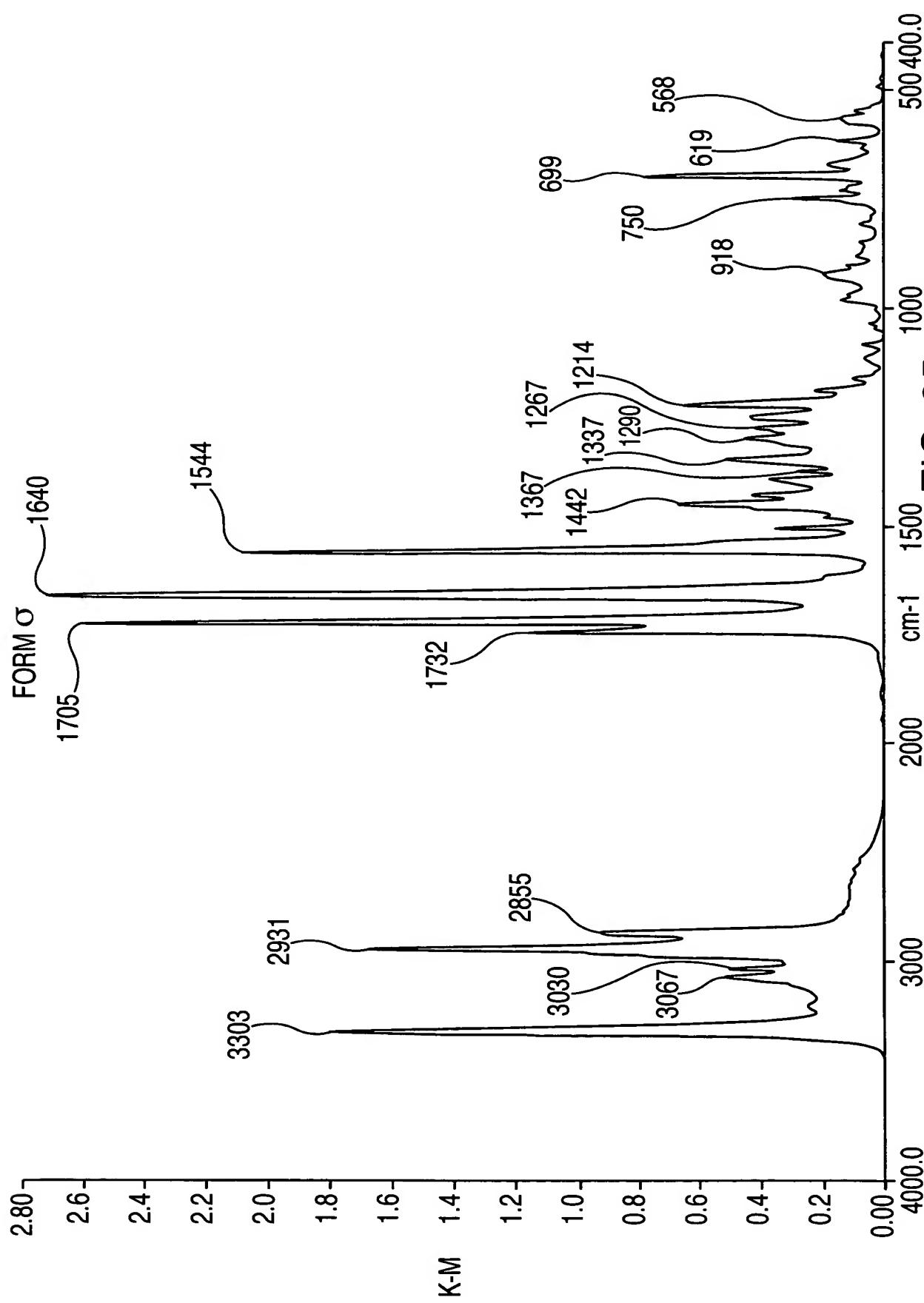




-DRIFT, 4000-400 CM^{-1} , 16 SCANS, RESOLUTION: 4.00 cm^{-1} FIG. 33



-DRIFT, 4000-400 CM^{-1} , 16 SCANS, RESOLUTION: 4.0 cm^{-1} FIG. 34



-DRIFT, 4000-400 CM^{-1} , 16 SCANS, RESOLUTION: 4.0 cm^{-1} FIG. 35

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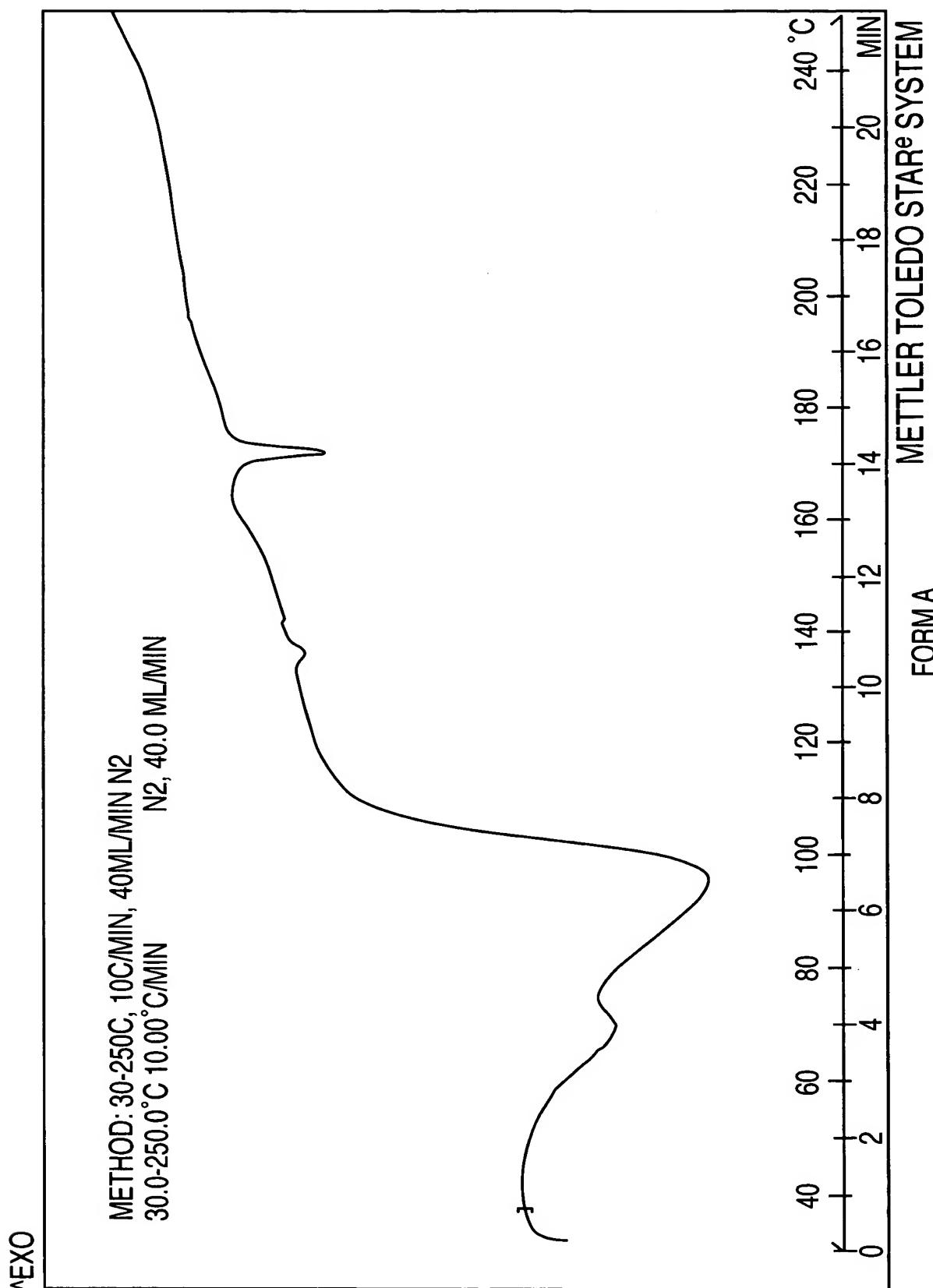
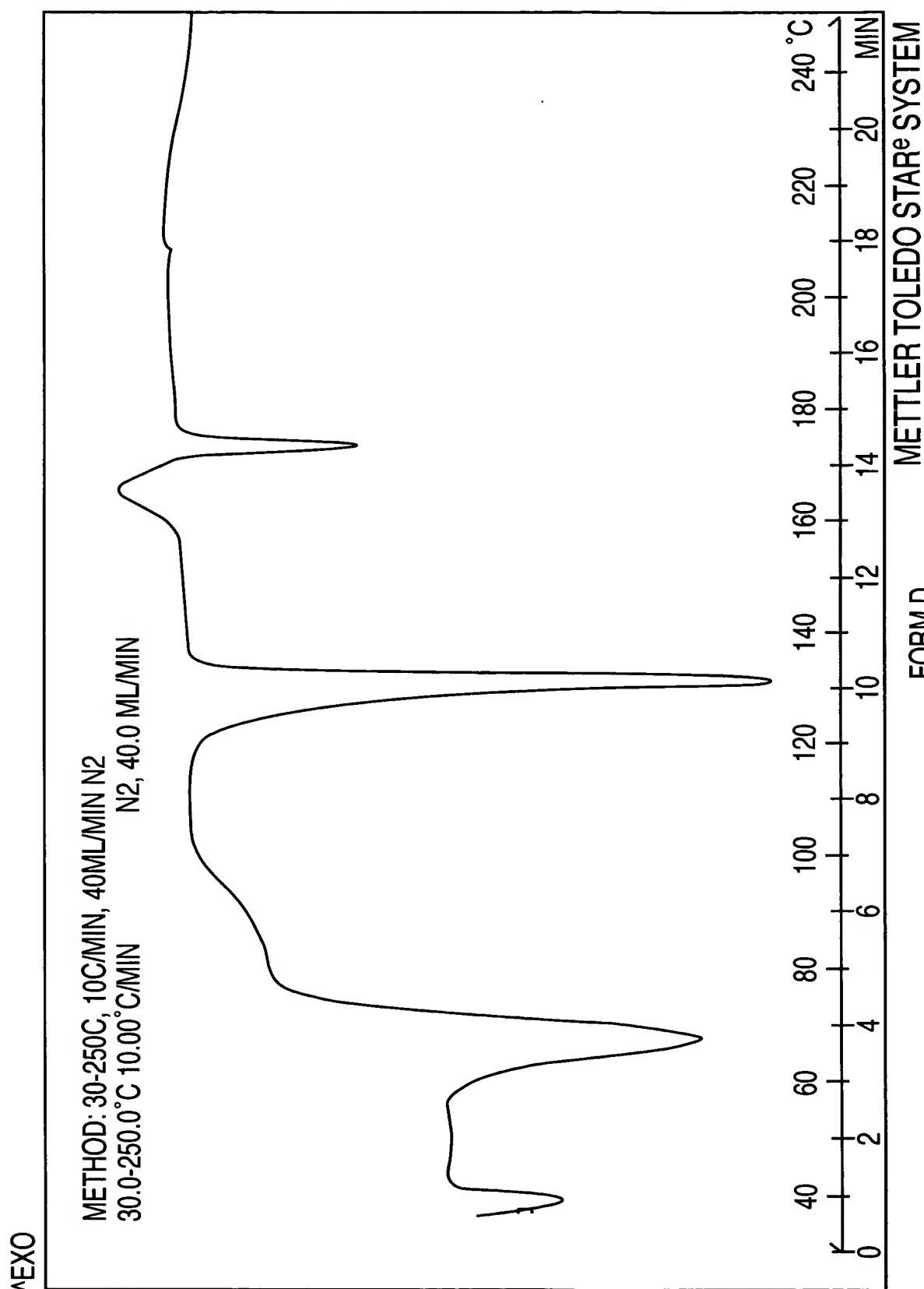


FIG. 36

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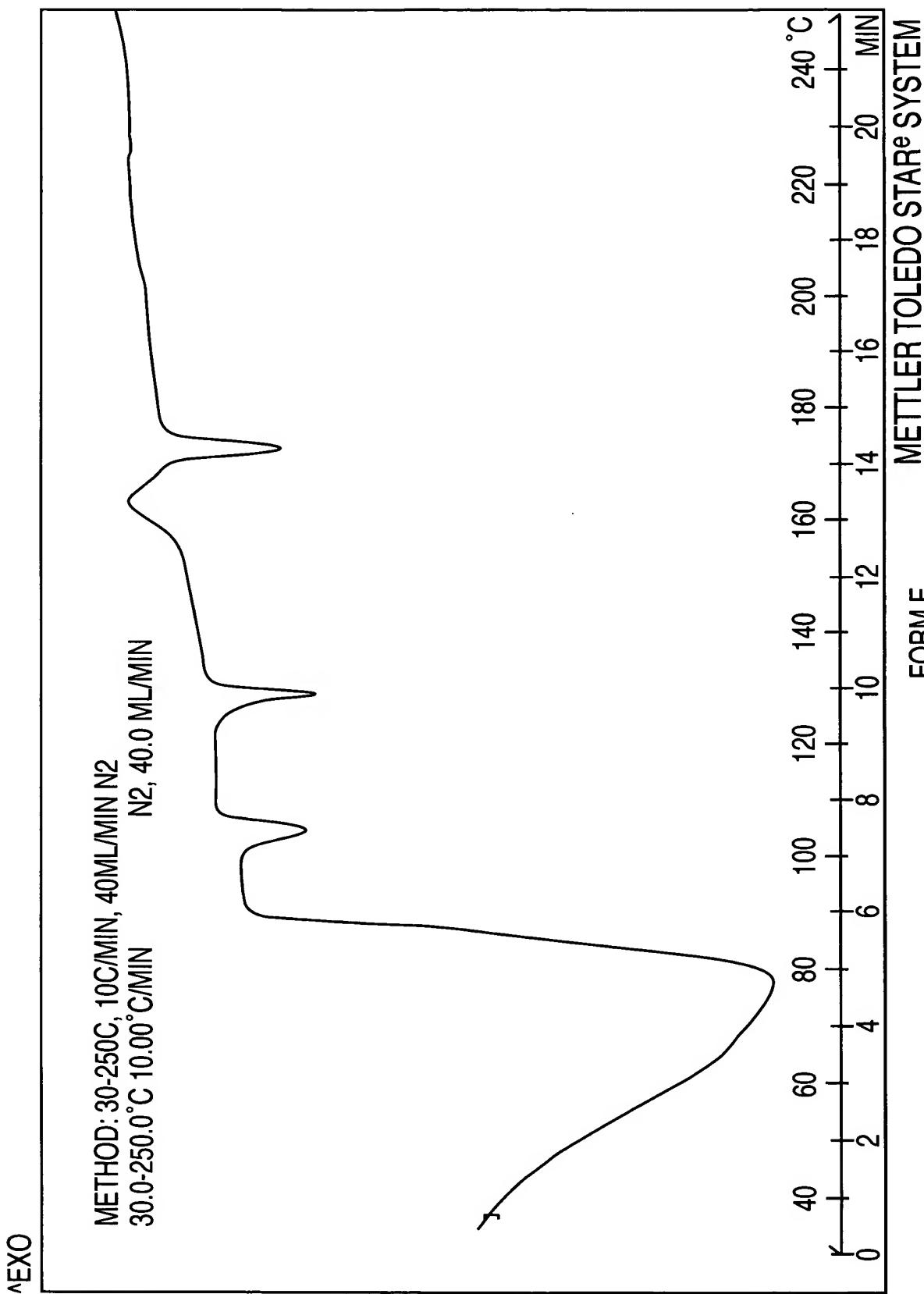


FIG. 38
FORM E
METTLER TOLEDO STAR^e SYSTEM

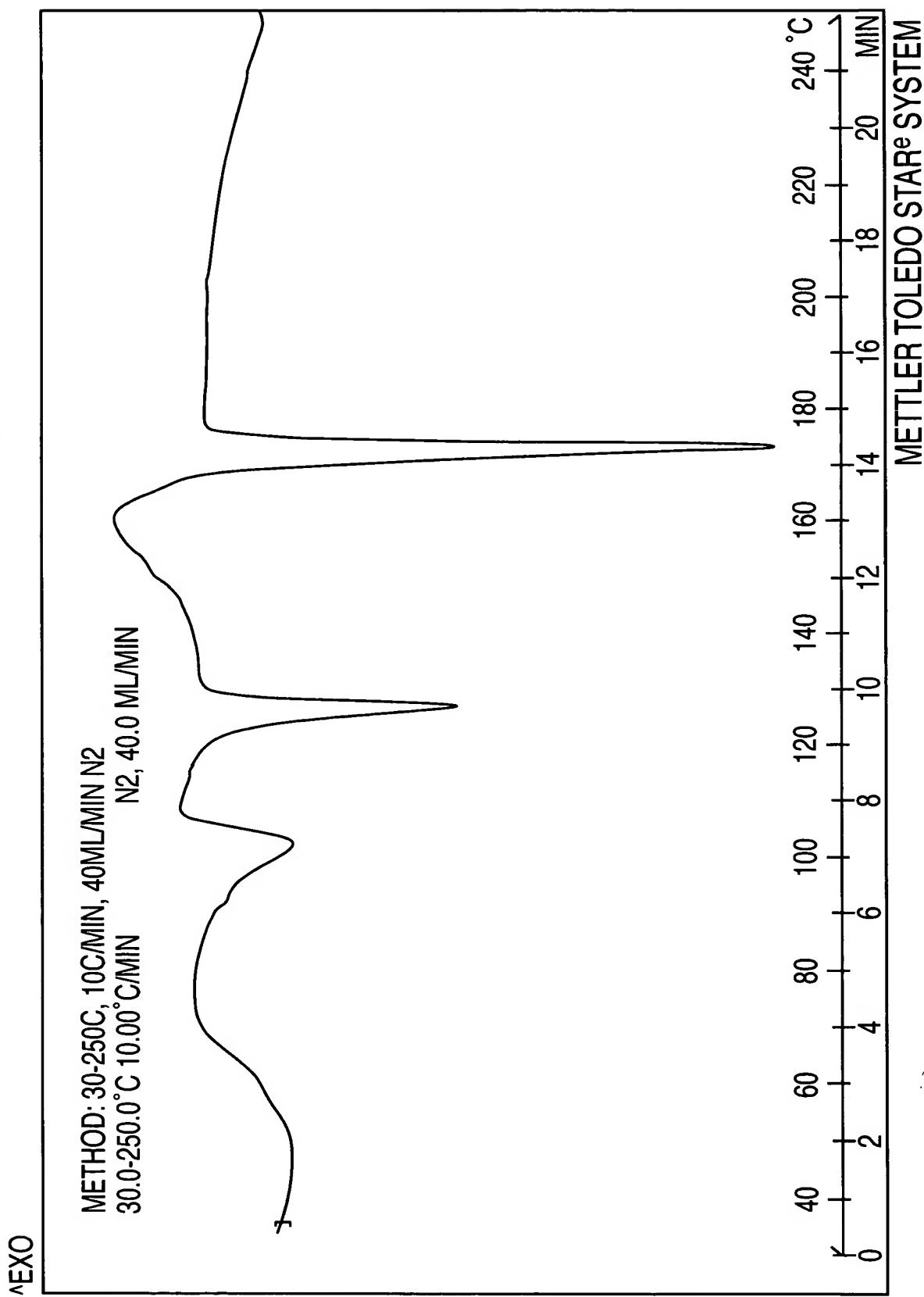


FIG. 39

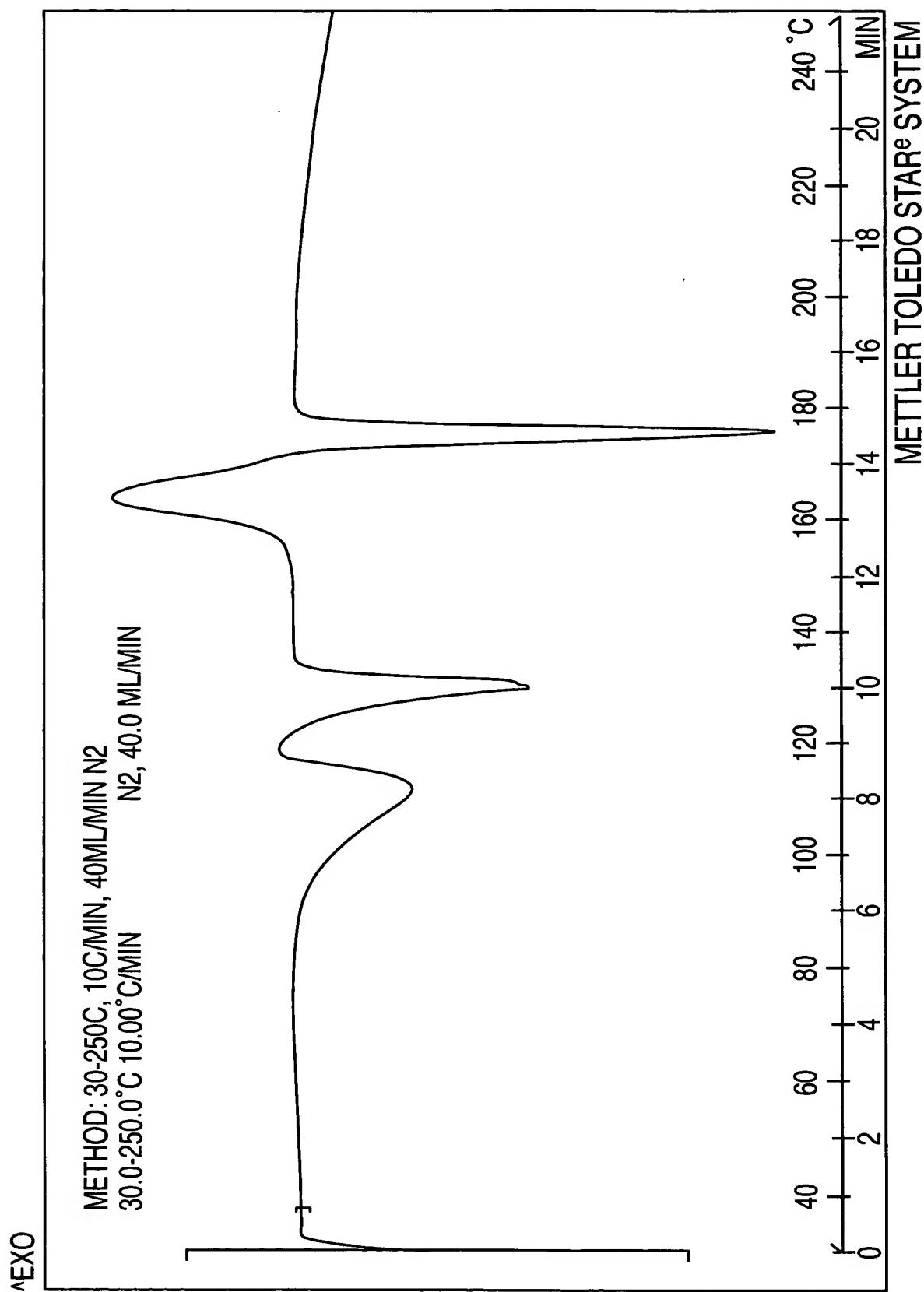


FIG. 40

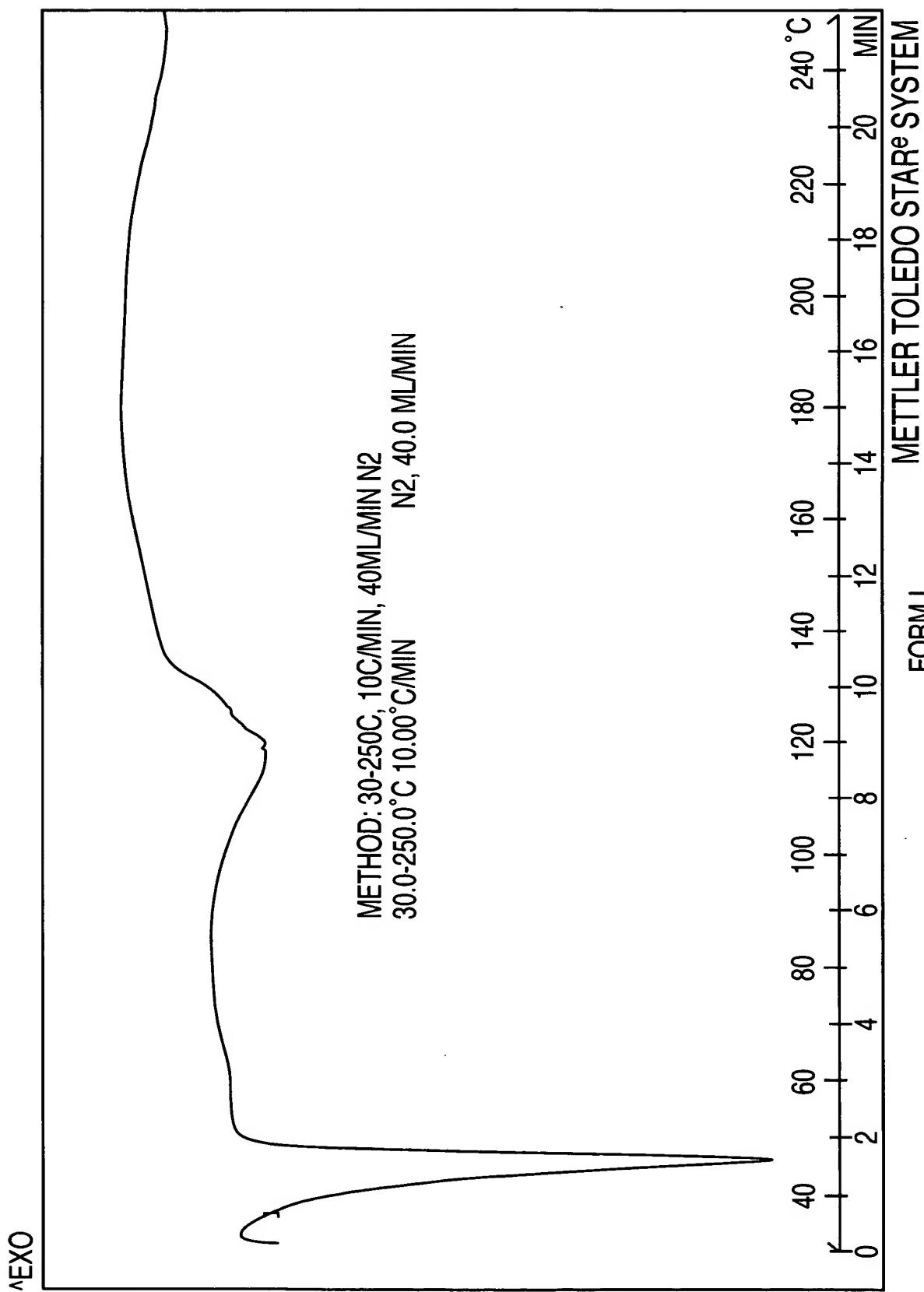


FIG. 41
FORM I
METTLER TOLEDO STAR^e SYSTEM

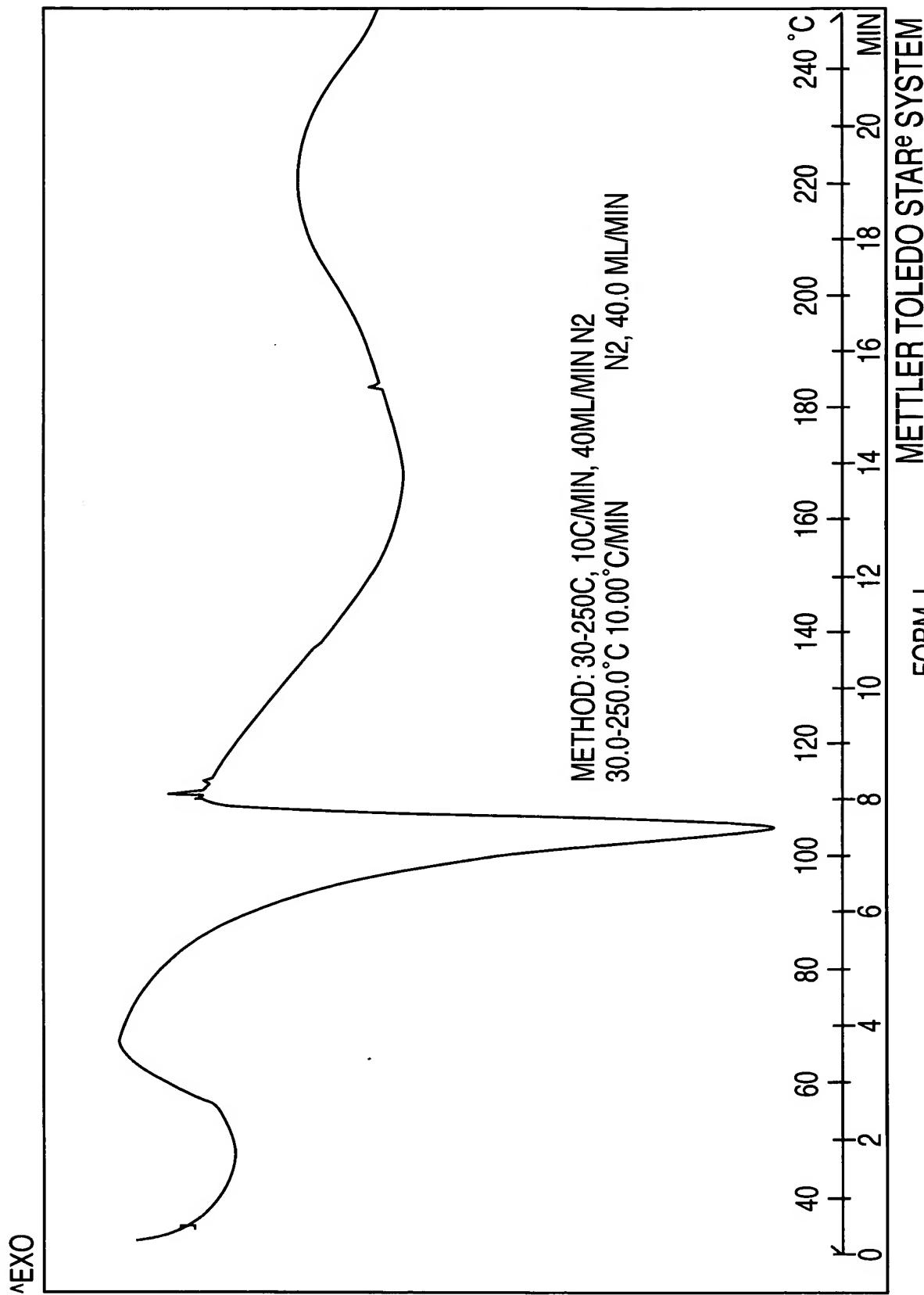


FIG. 42

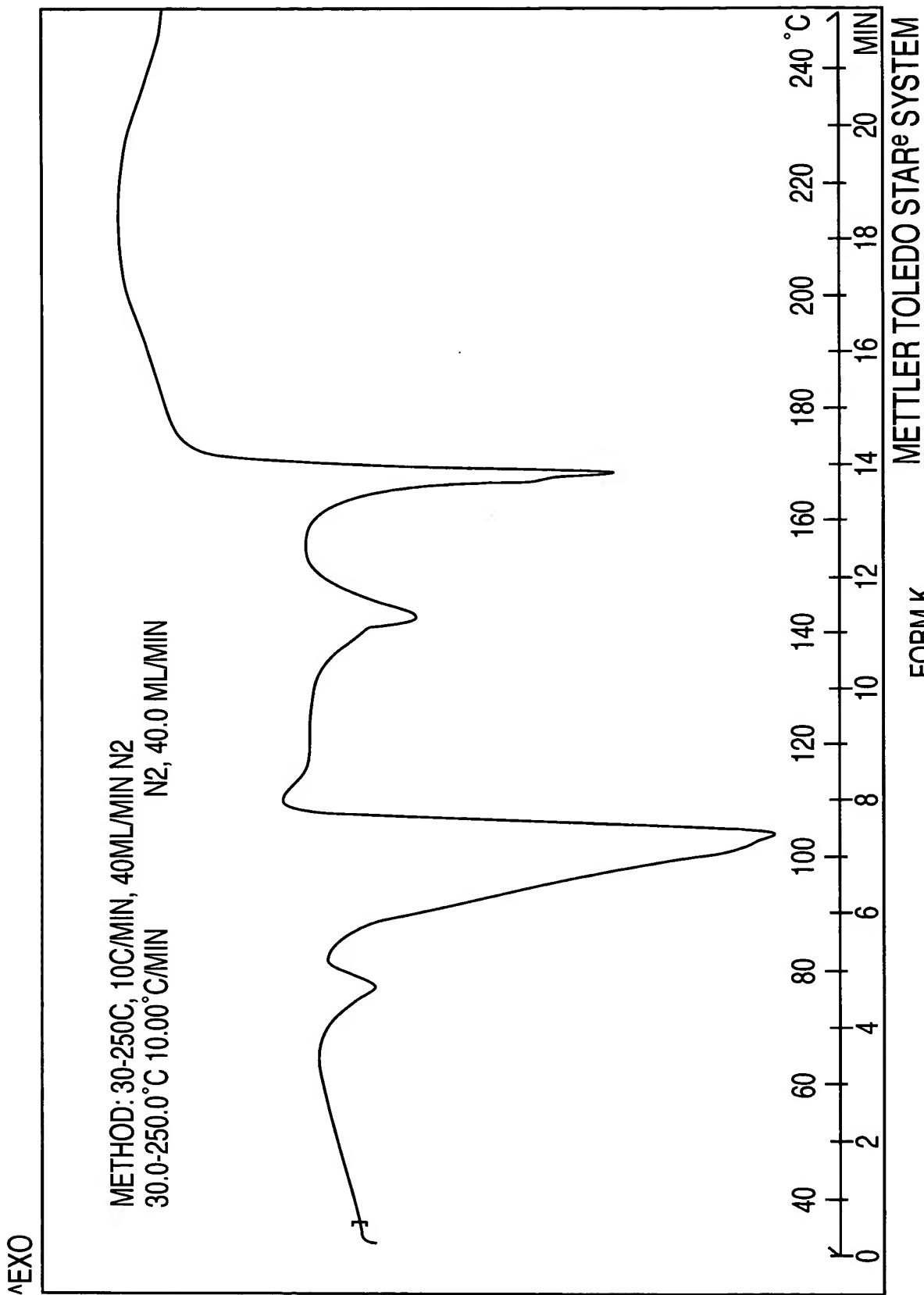
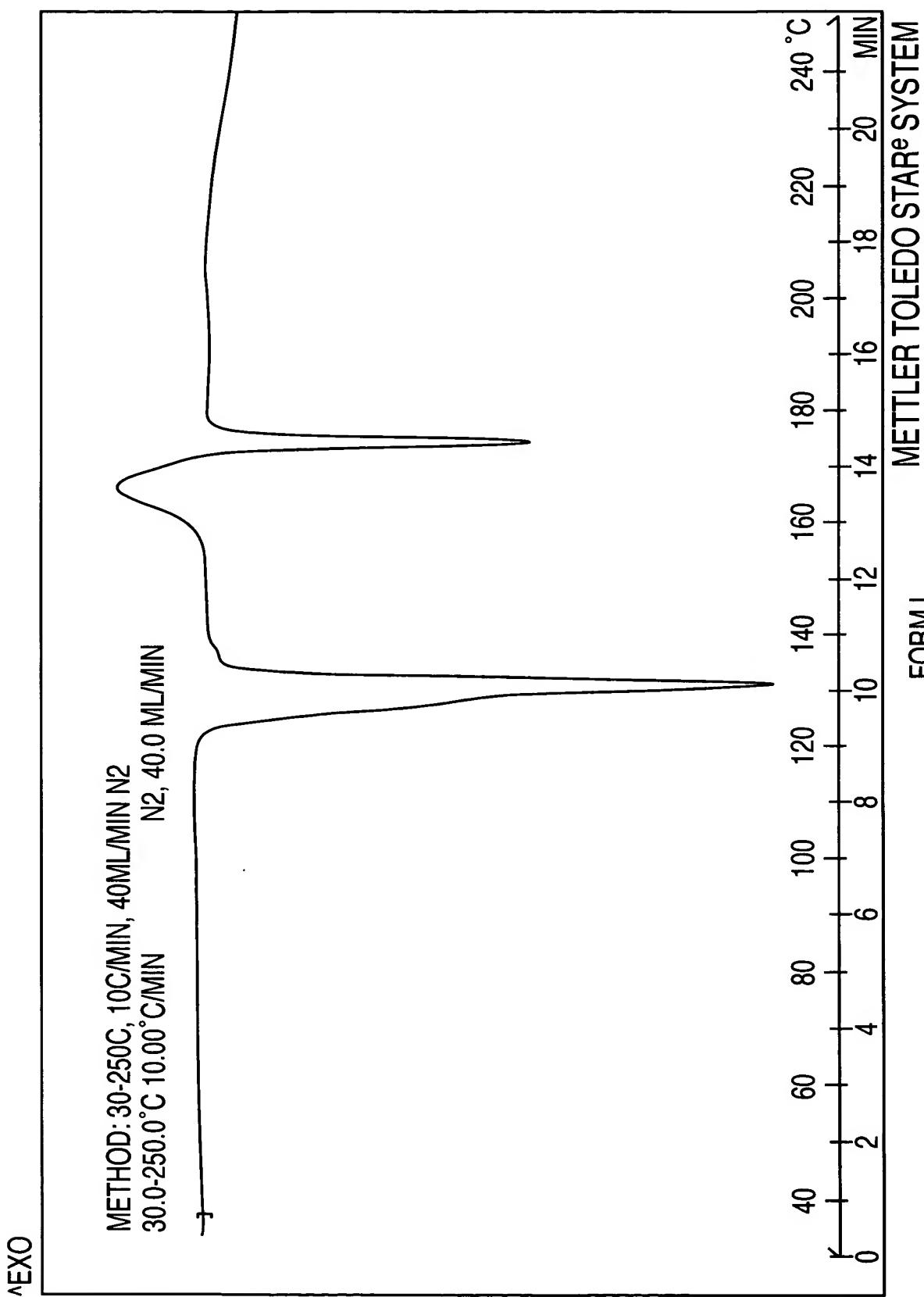


FIG. 43



FORM L
FIG. 44

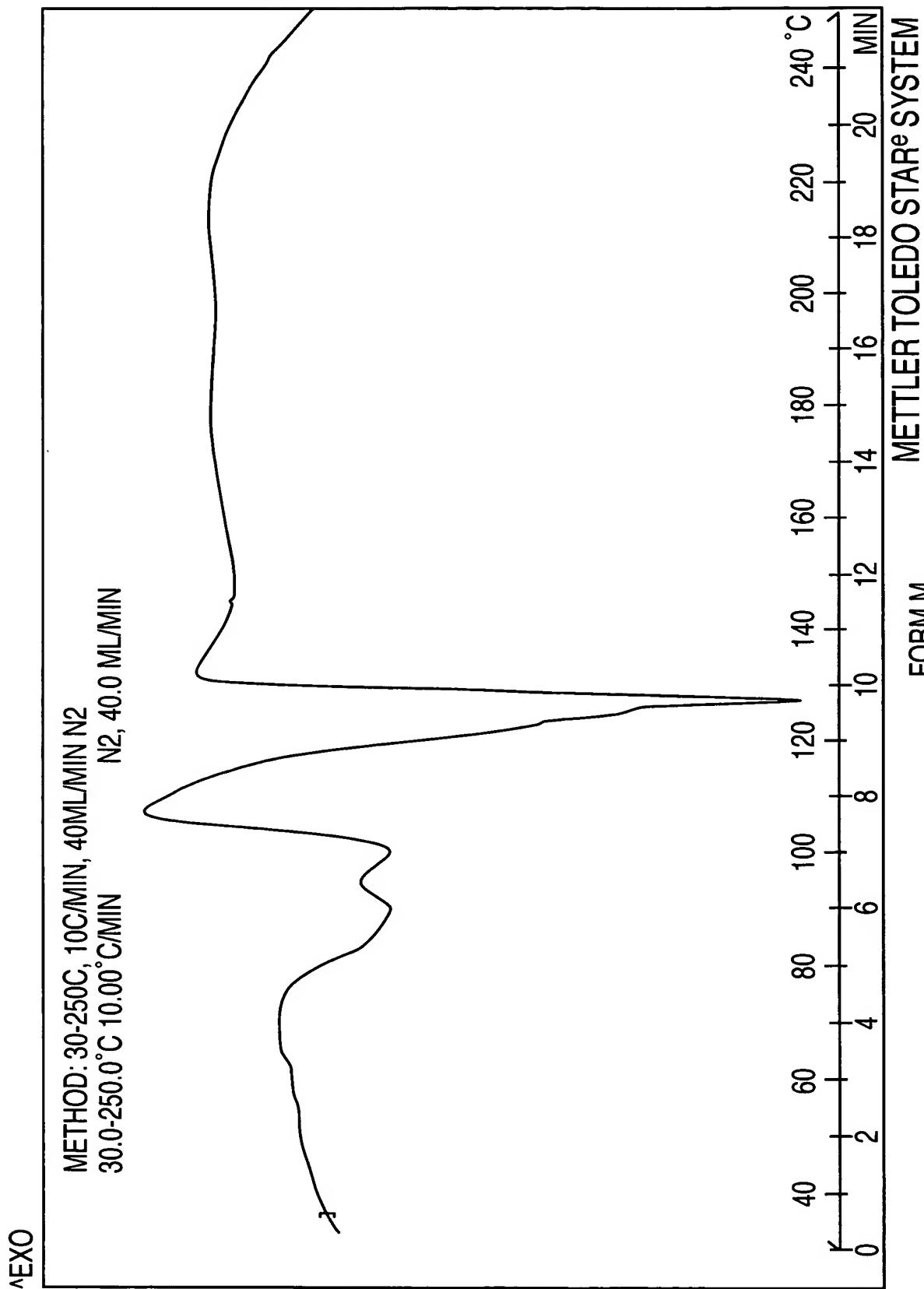
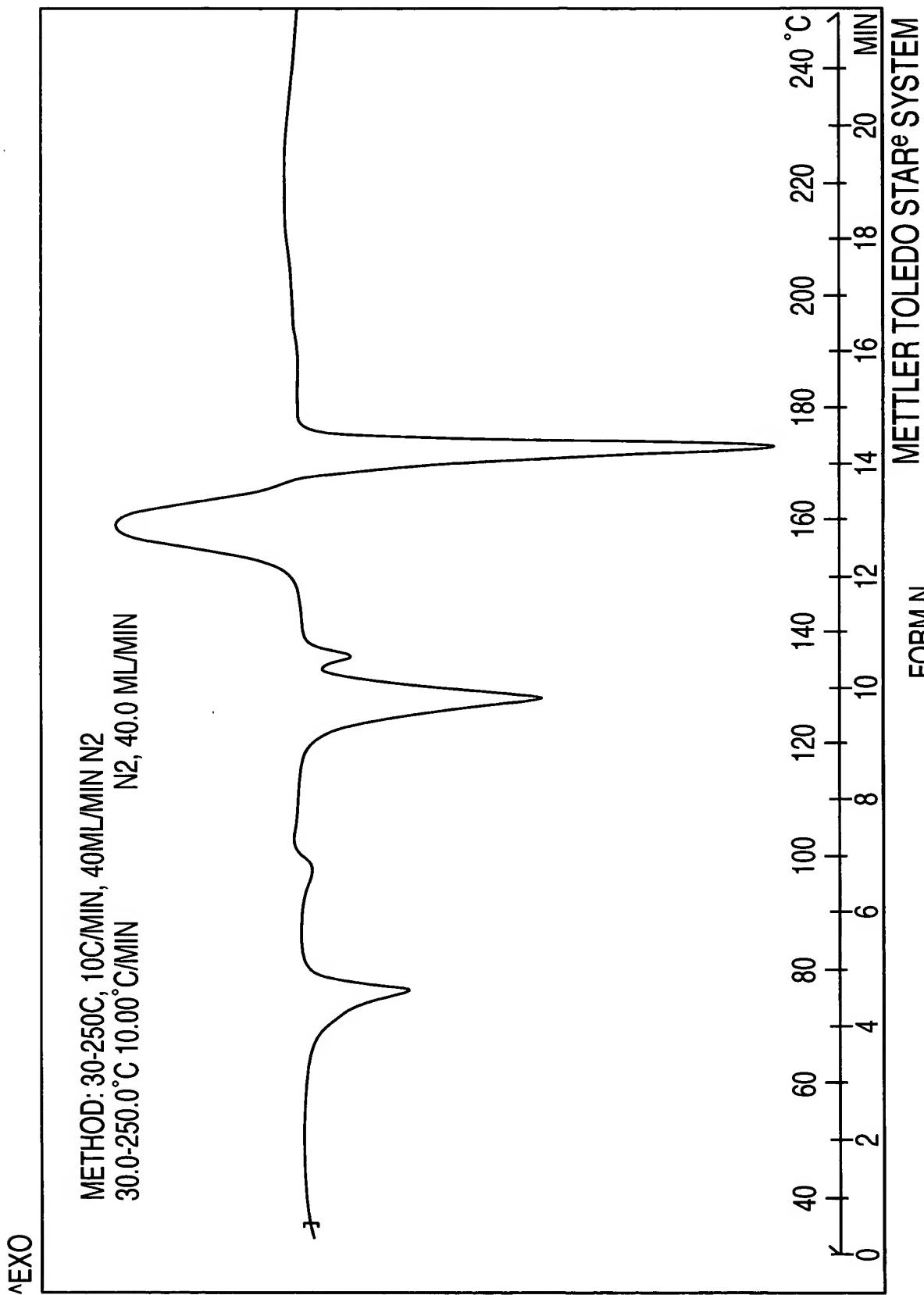
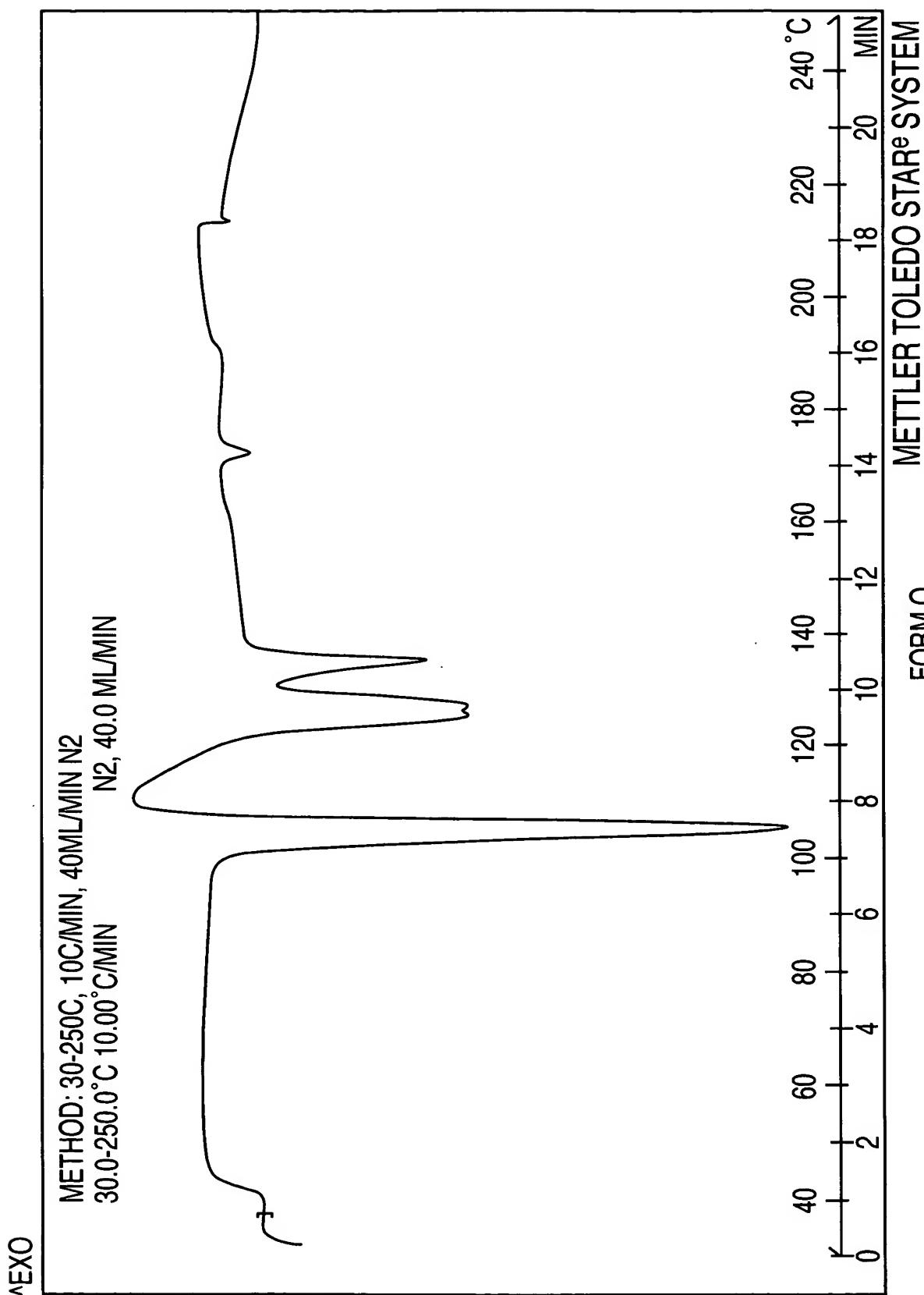


FIG. 45
FORM M
METTLER TOLEDO STAR^e SYSTEM

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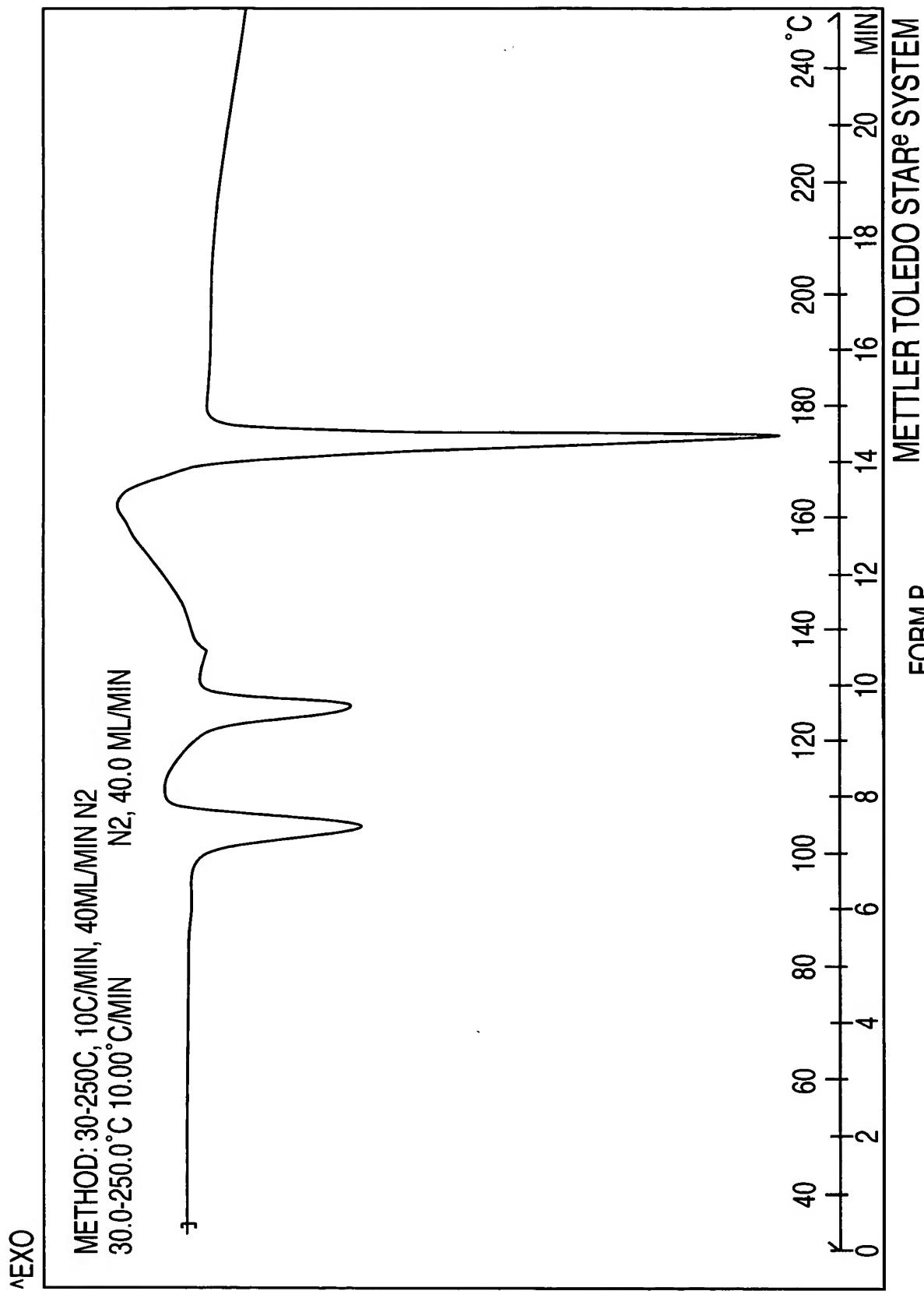


FIG. 48

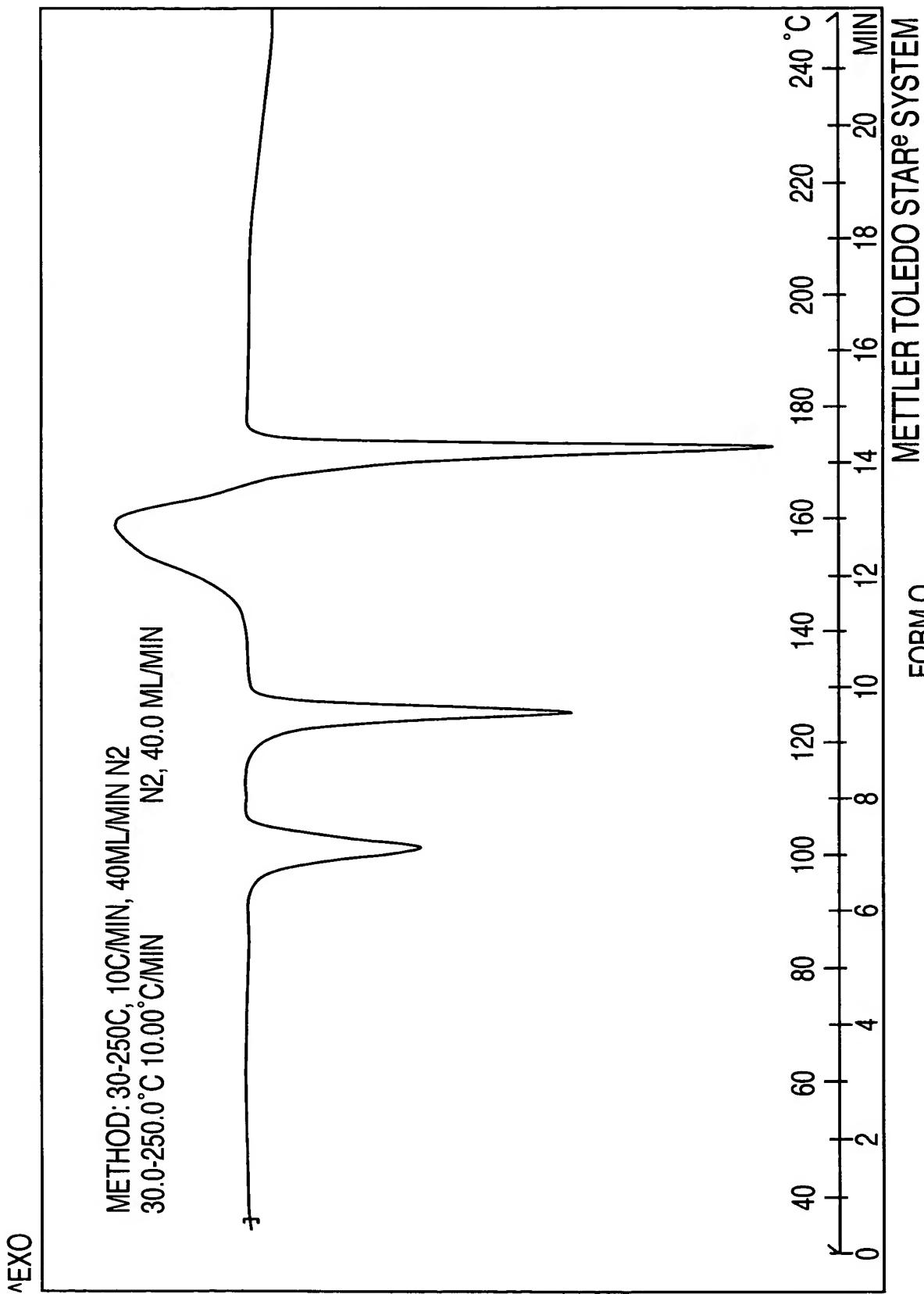


FIG. 49
METTLER TOLEDO STAR^e SYSTEM
FORM Q

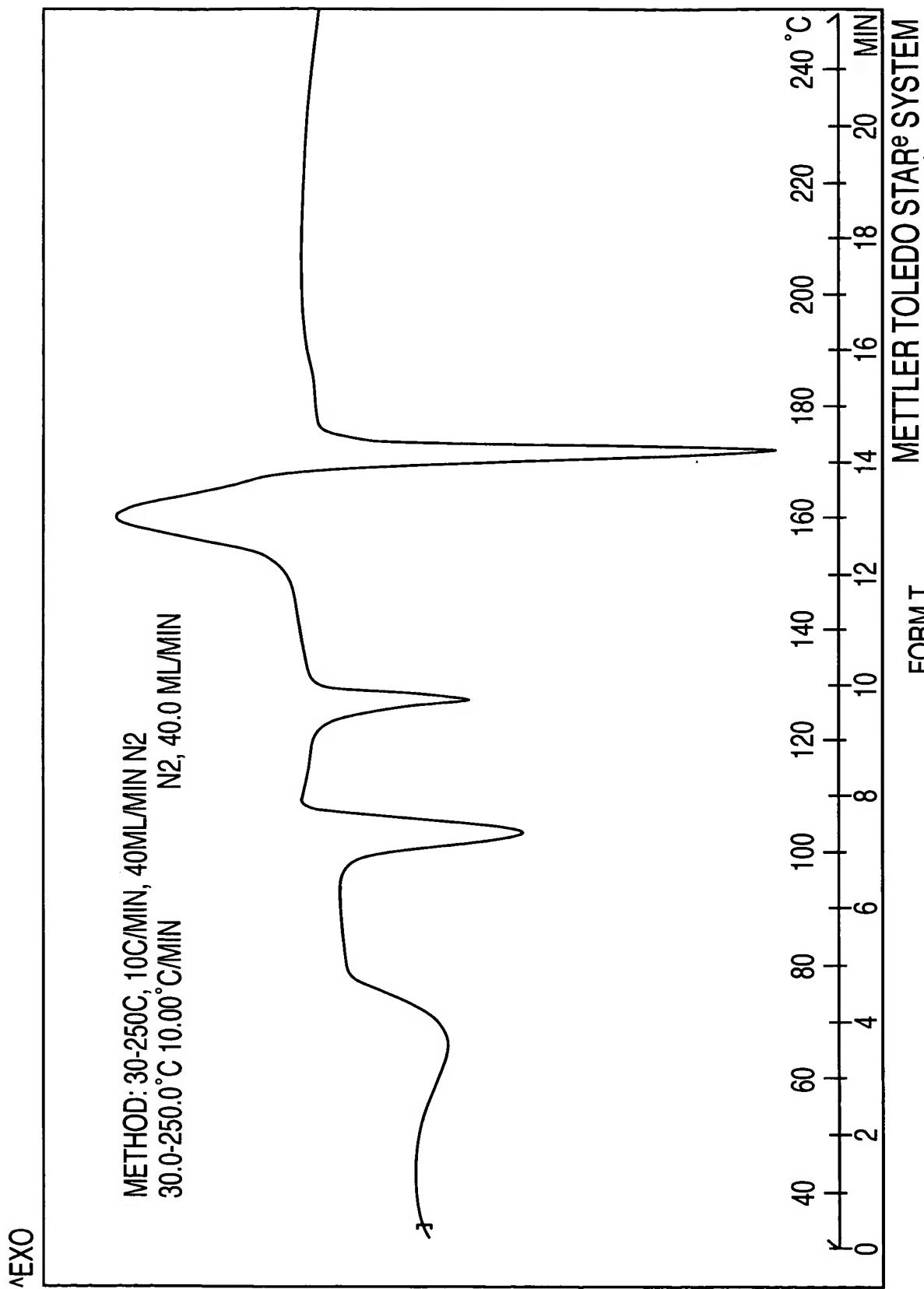


FIG. 50

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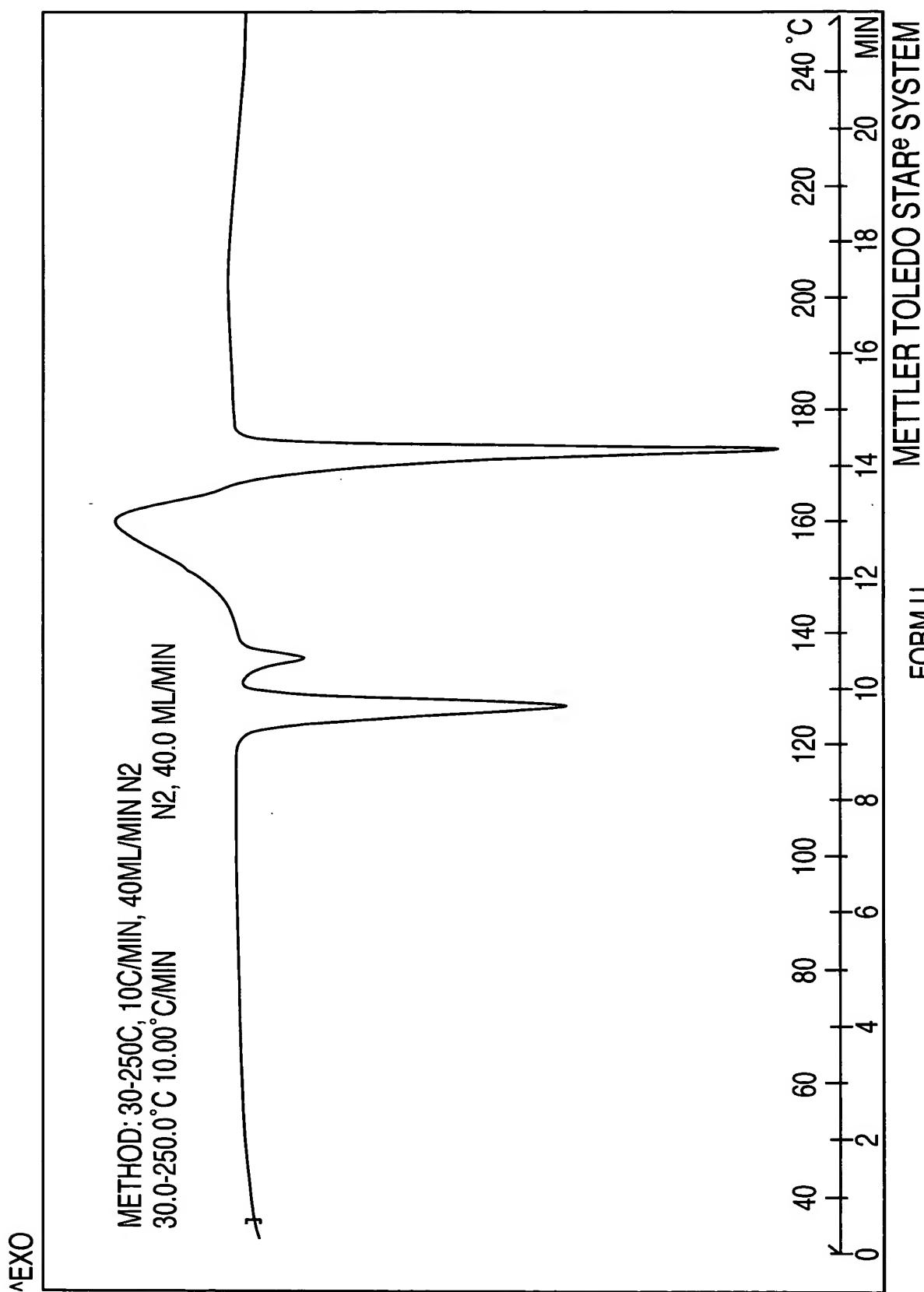


FIG. 51

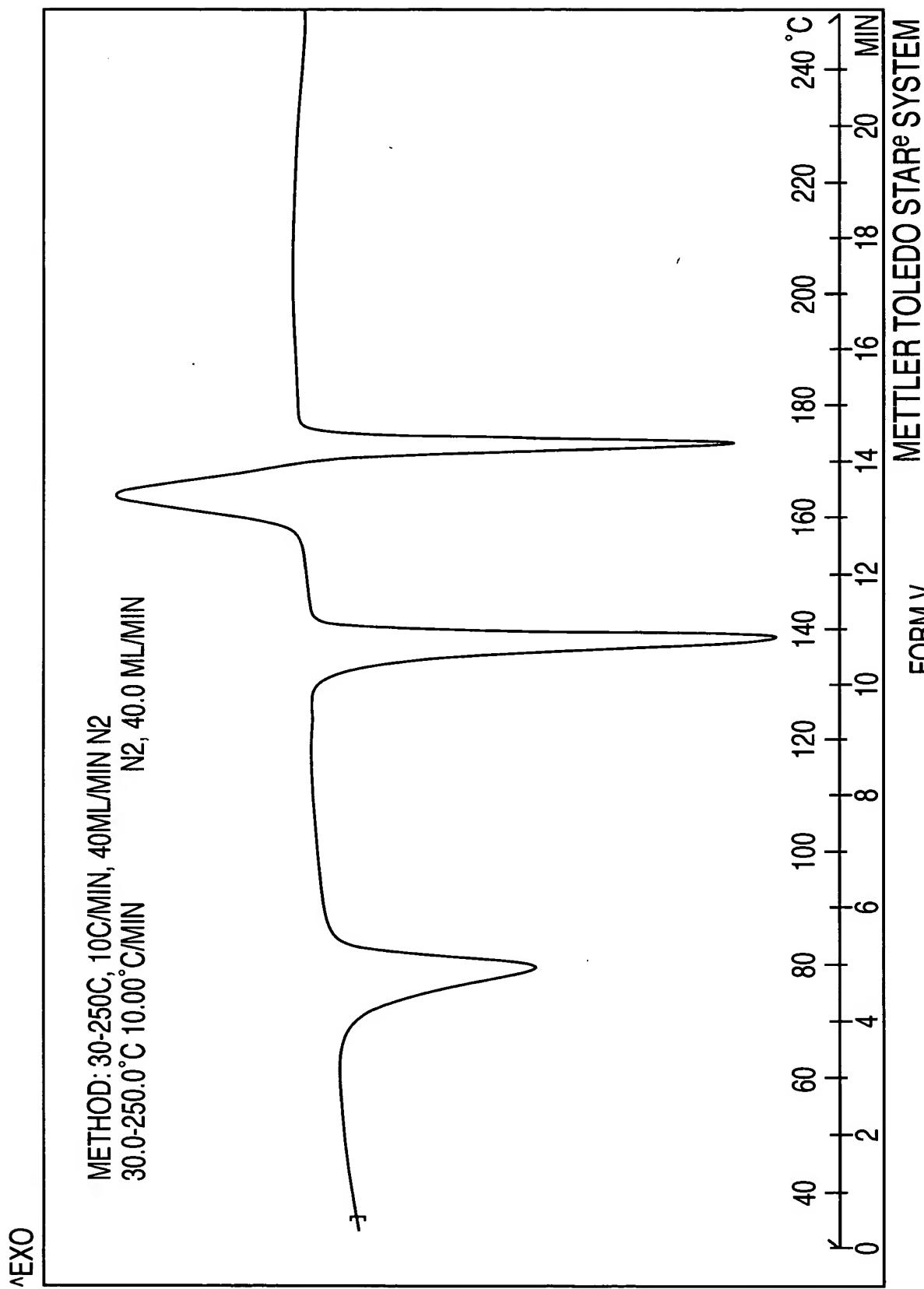
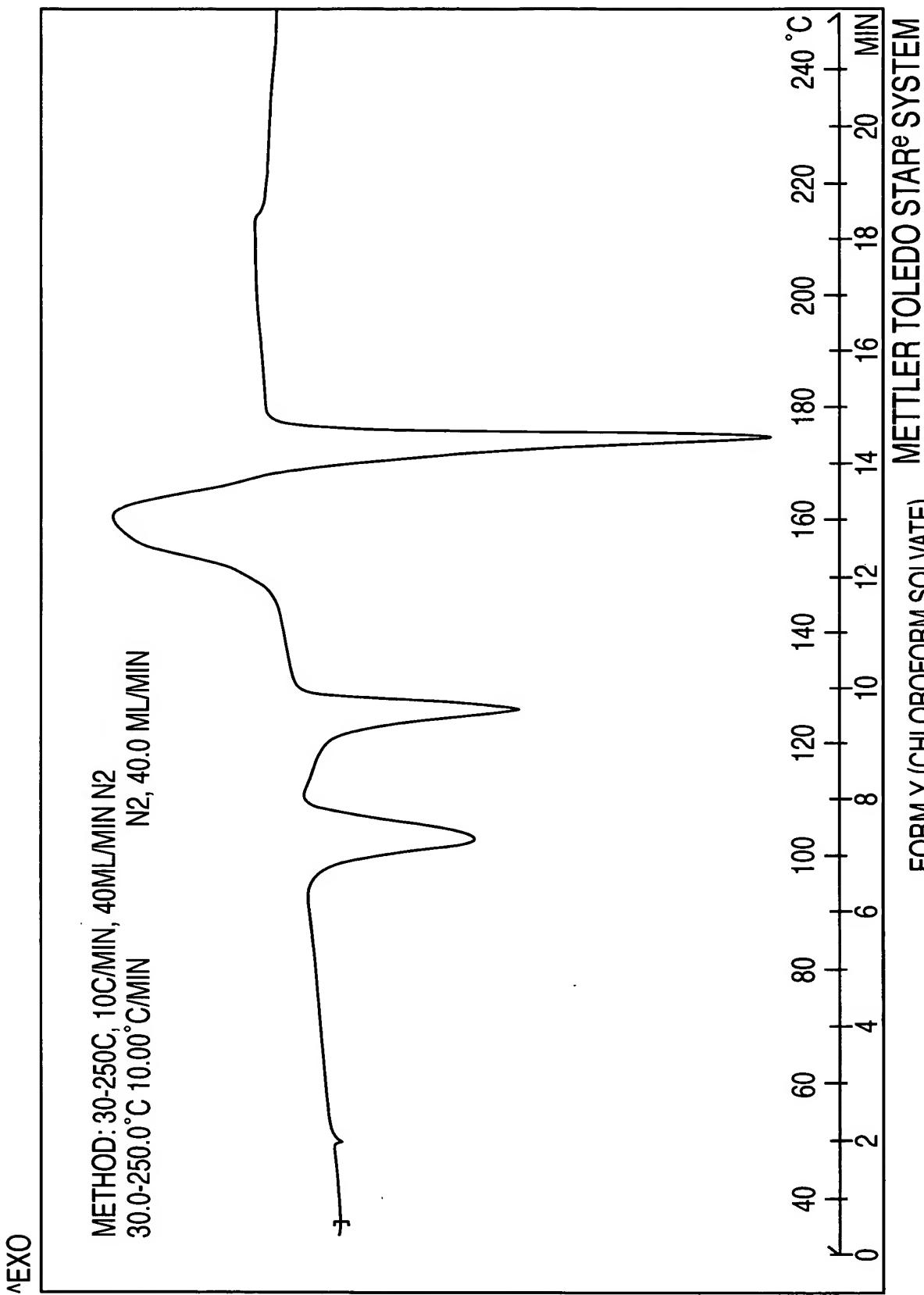


FIG. 52
FORM V
METTLER TOLEDO STAR^e SYSTEM



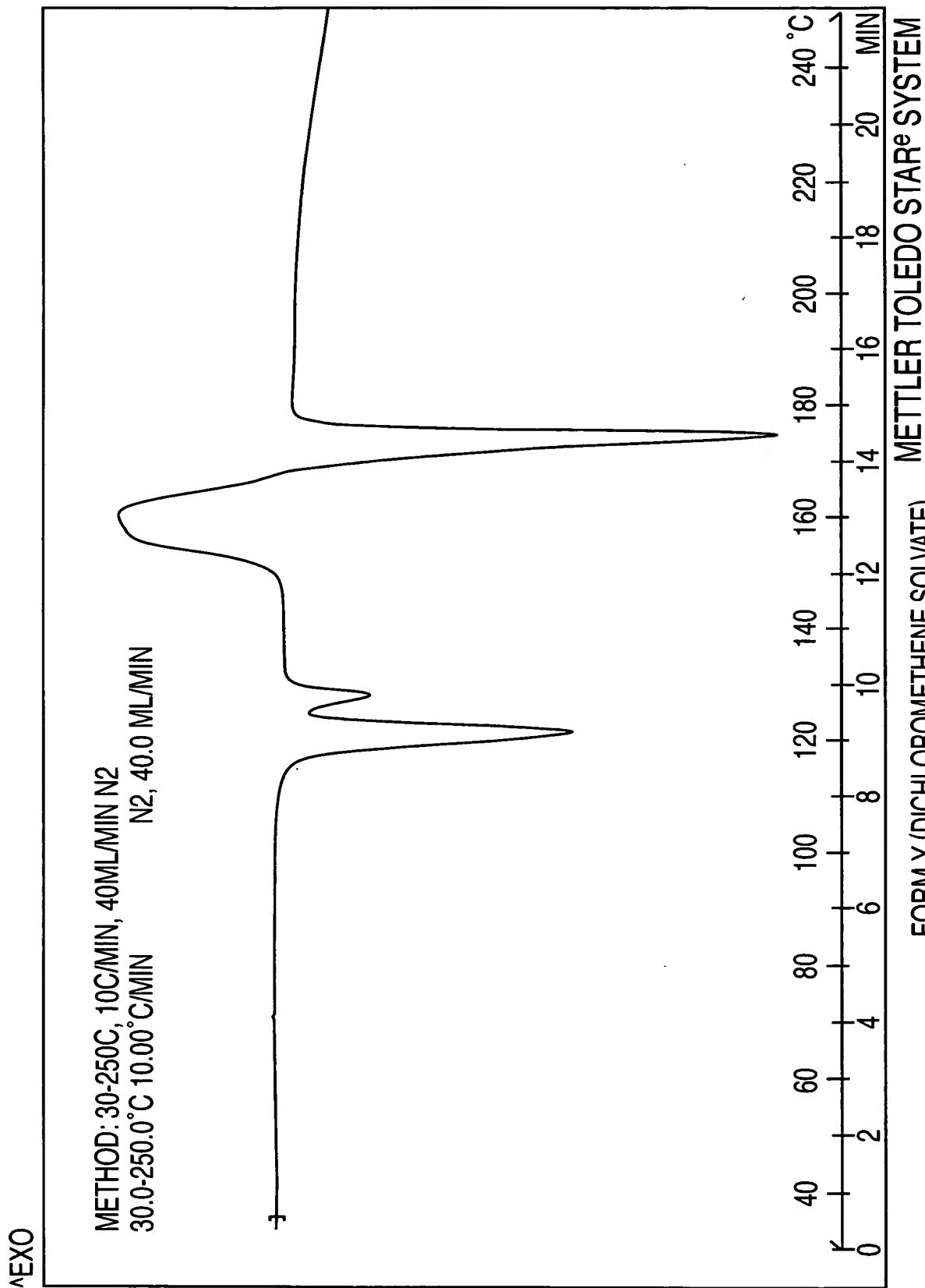


FIG. 54

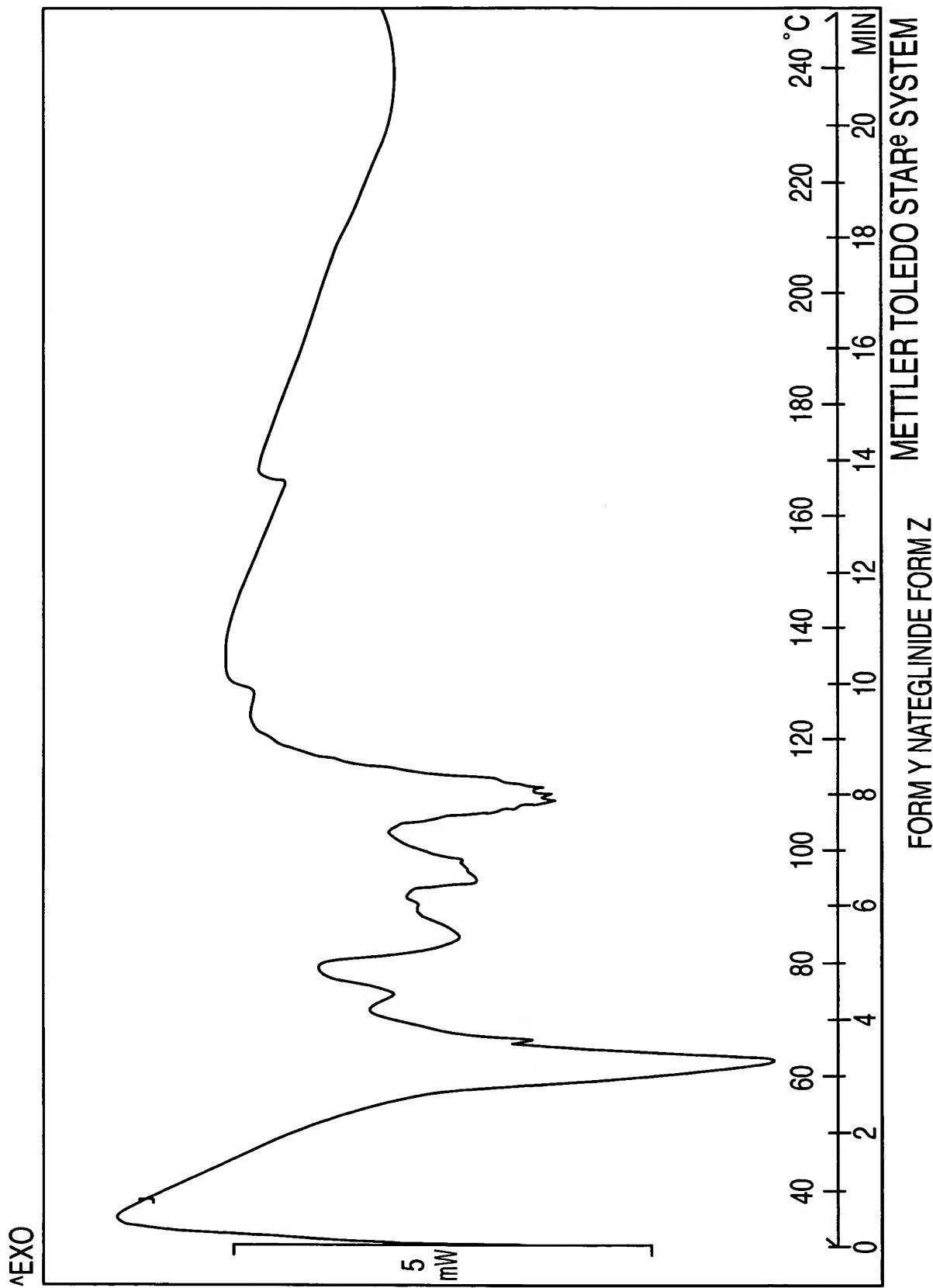


FIG. 55

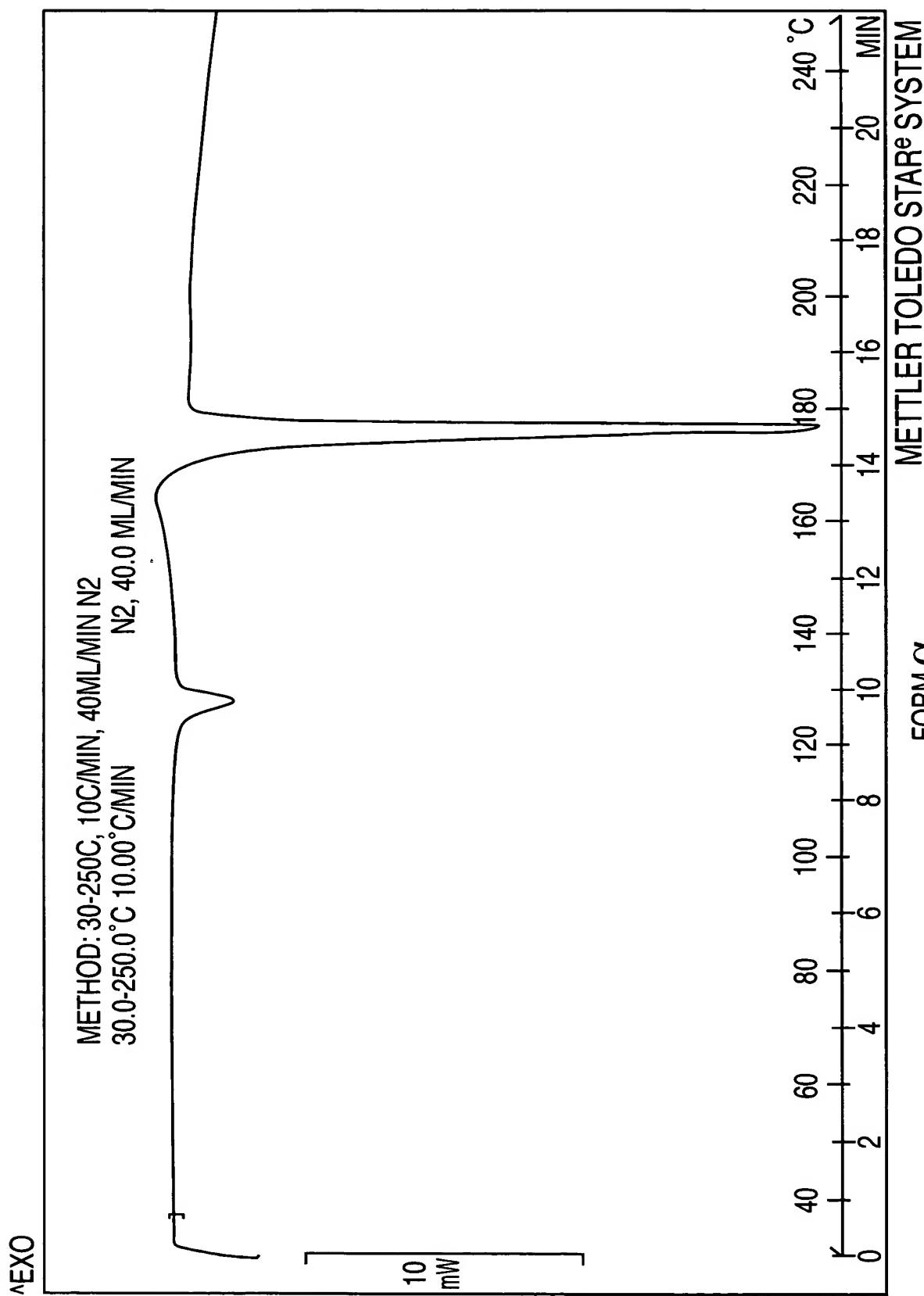
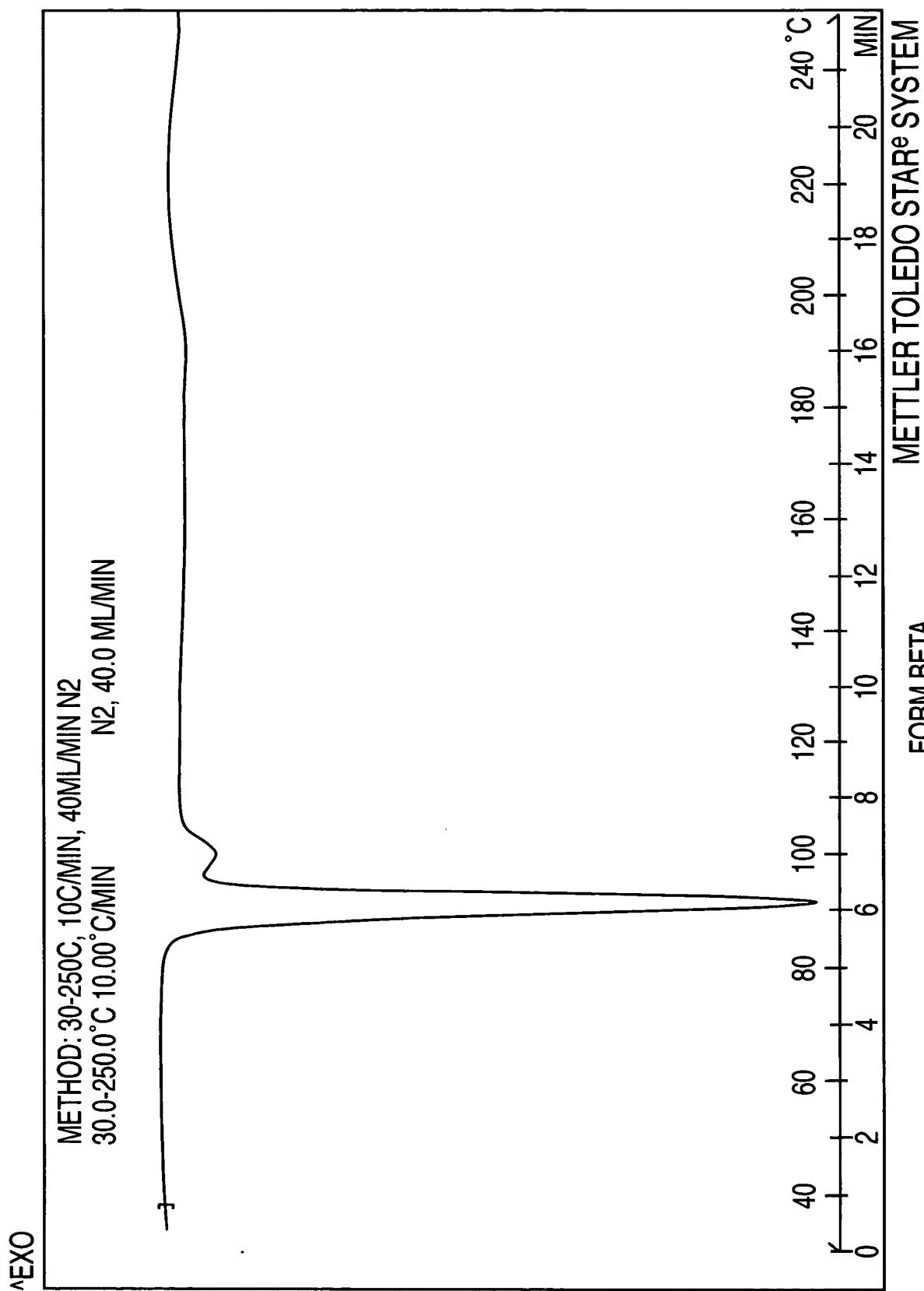
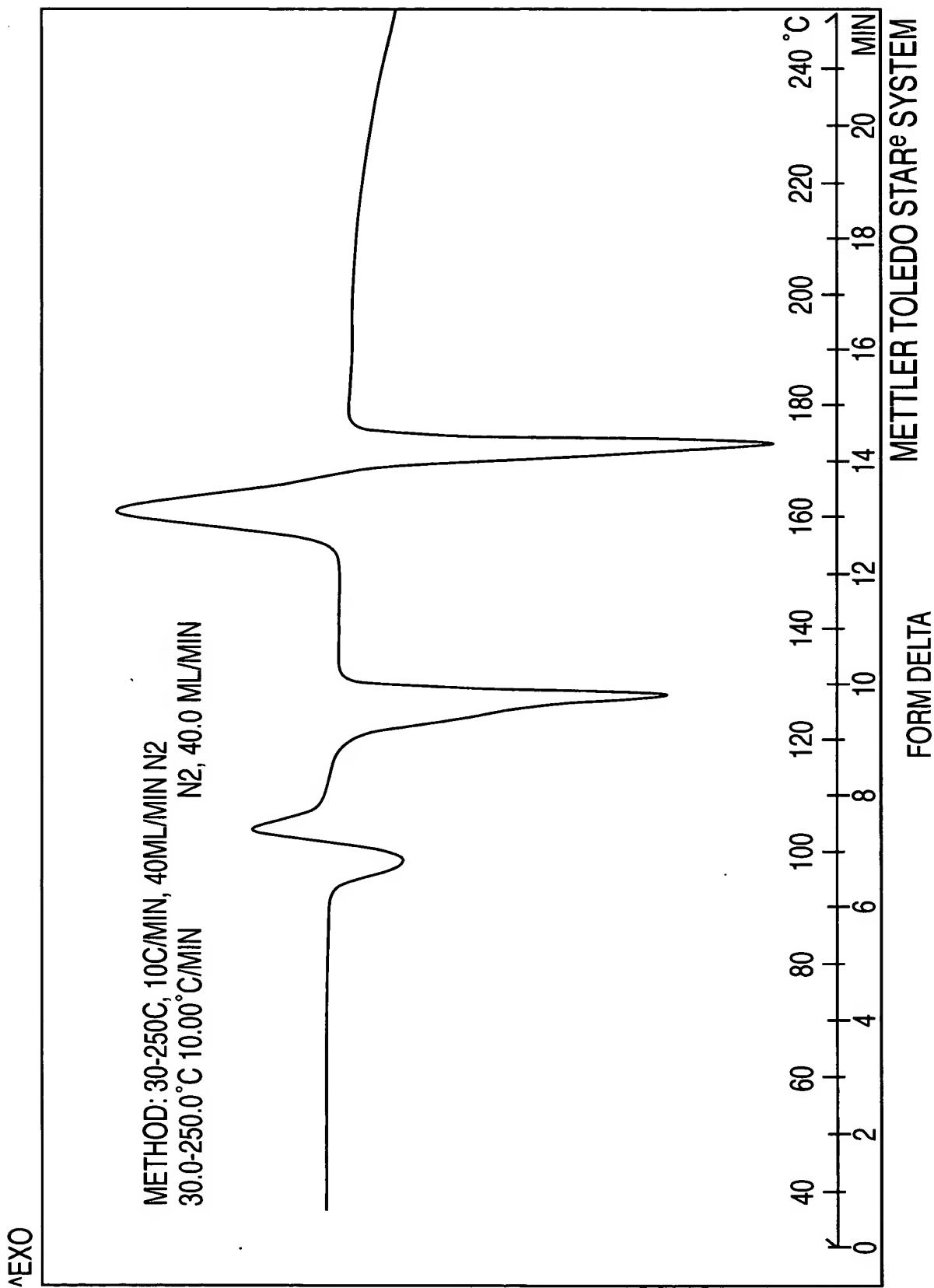
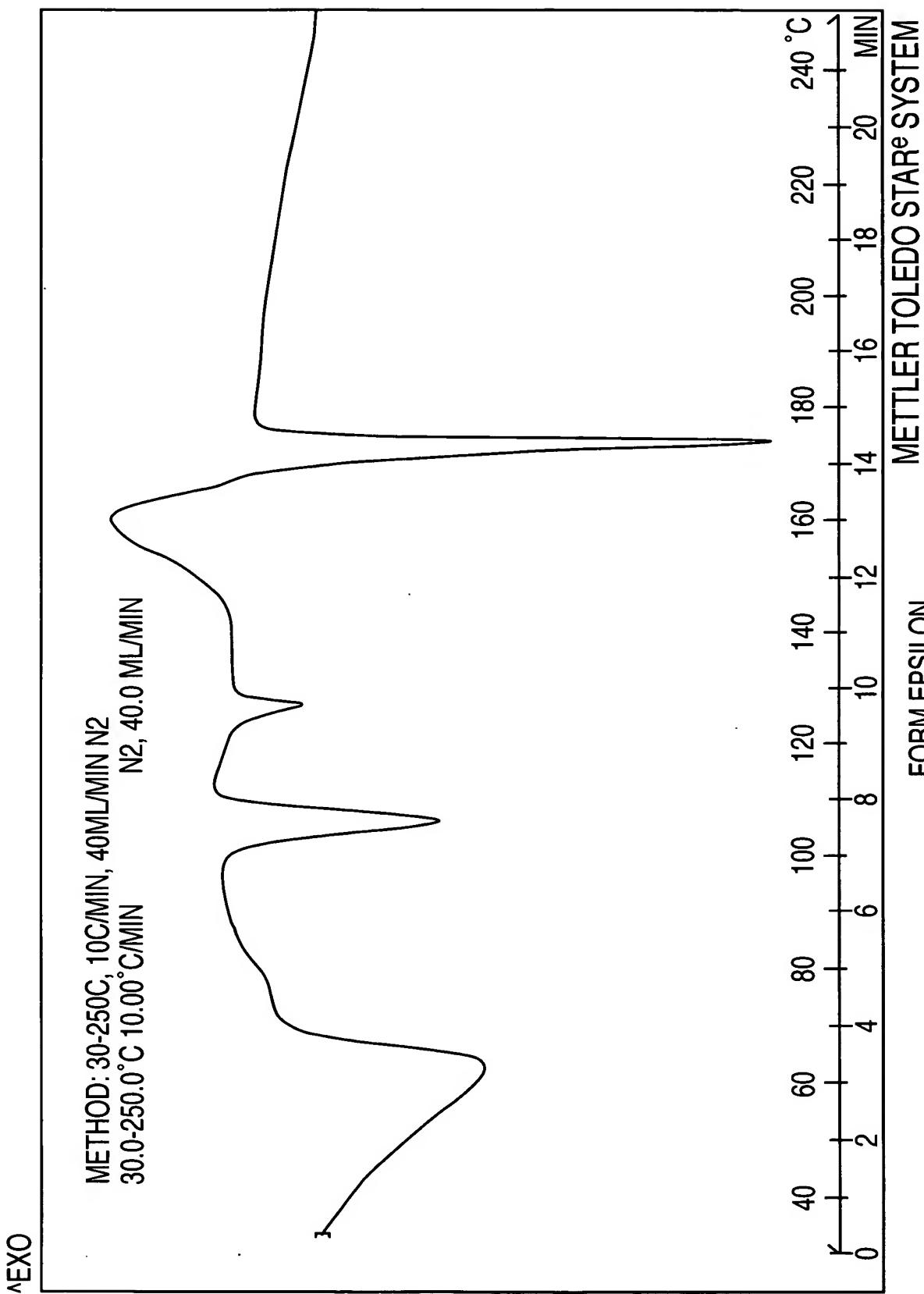


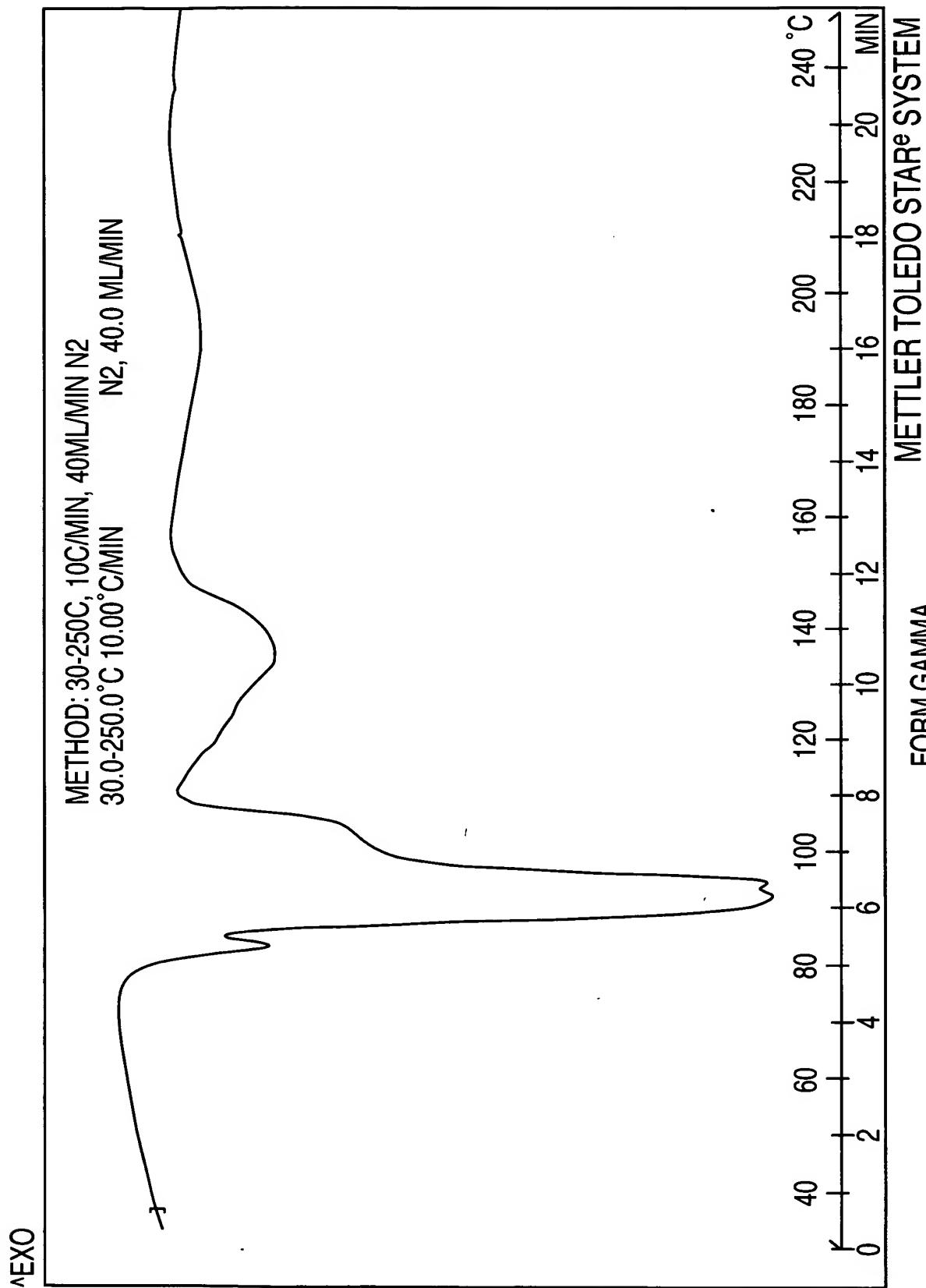
FIG. 56







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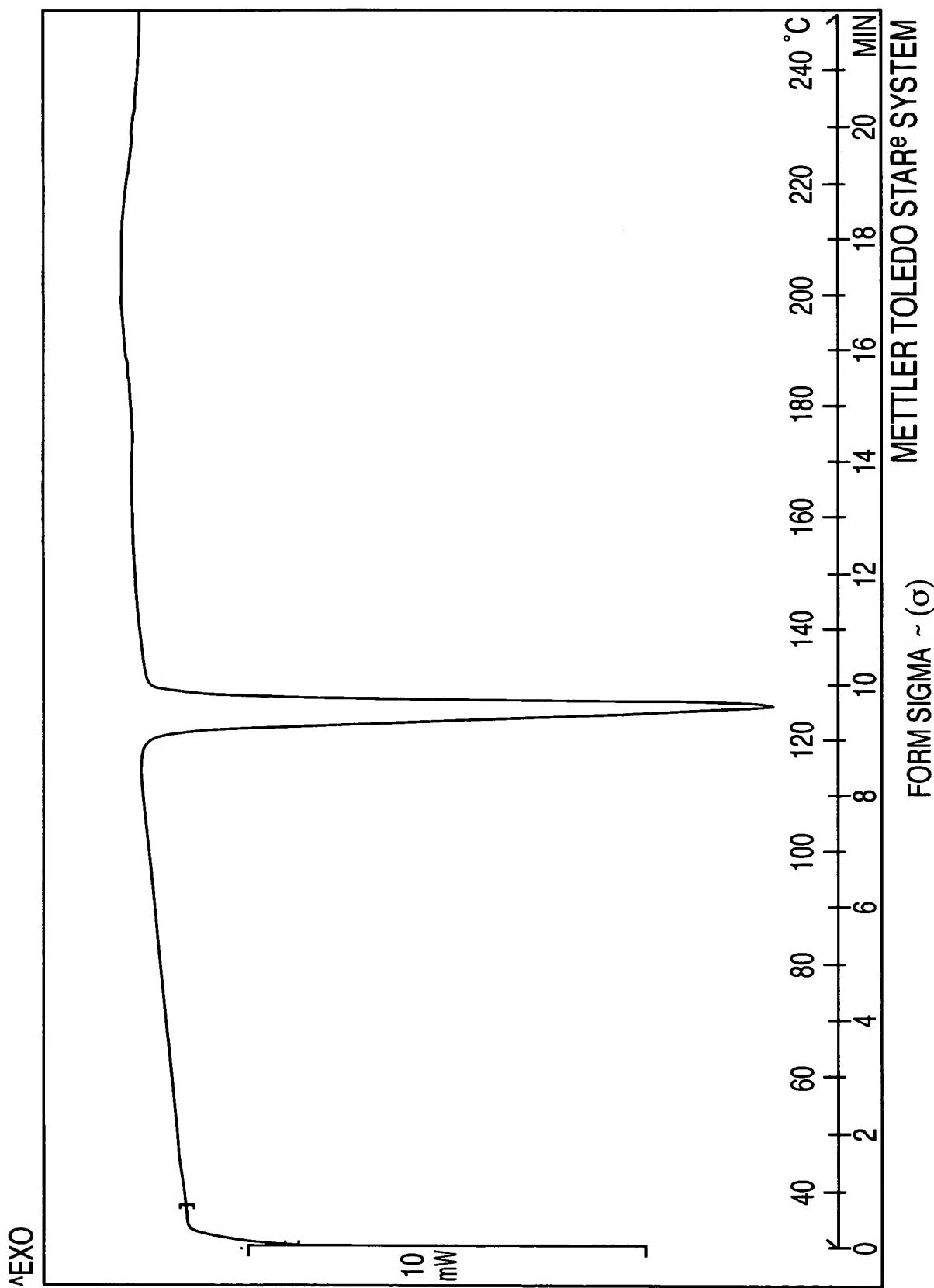


FIG. 61

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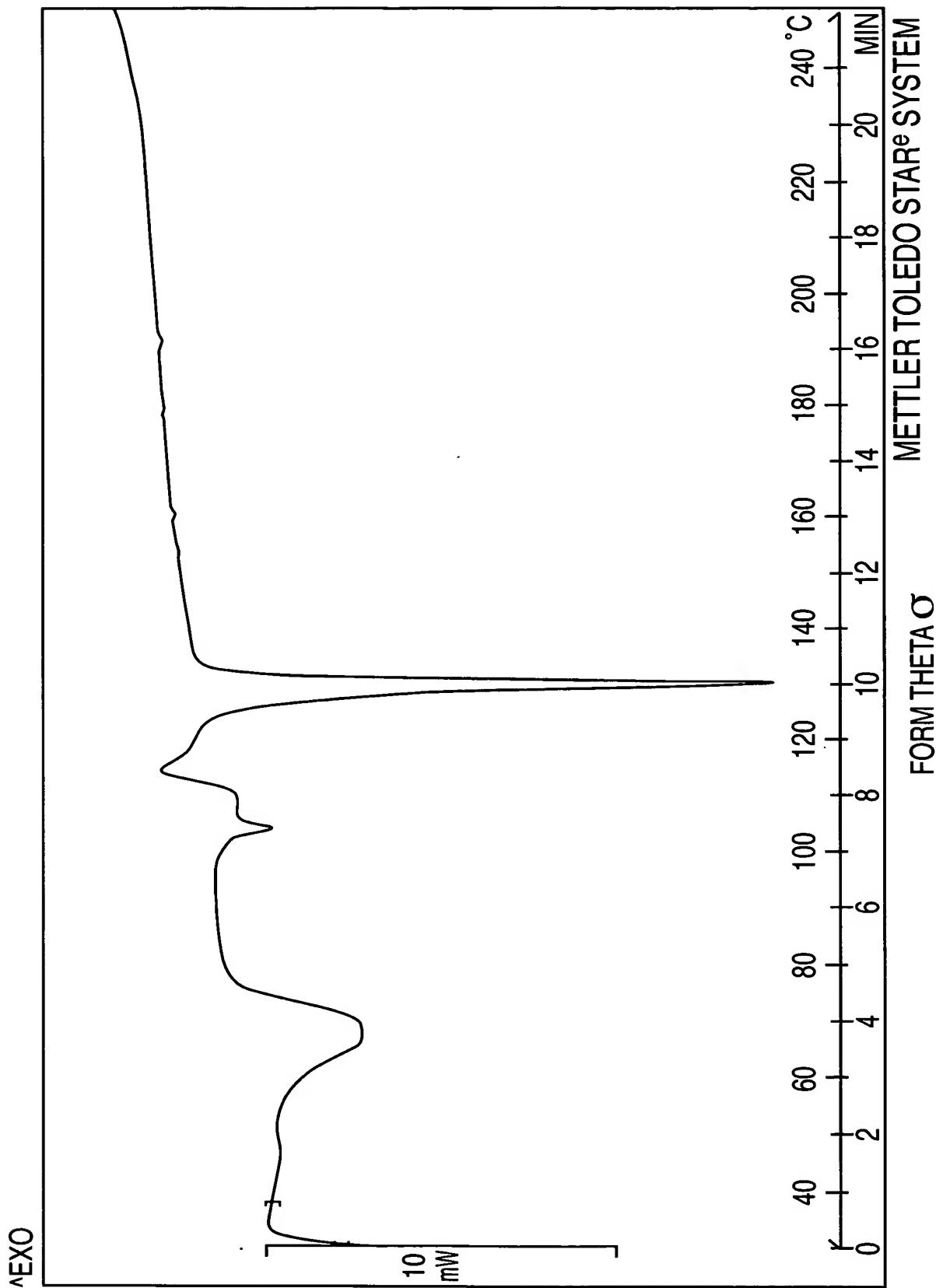


FIG. 62
FORM THETA σ
METTLER TOLEDO STAR σ SYSTEM

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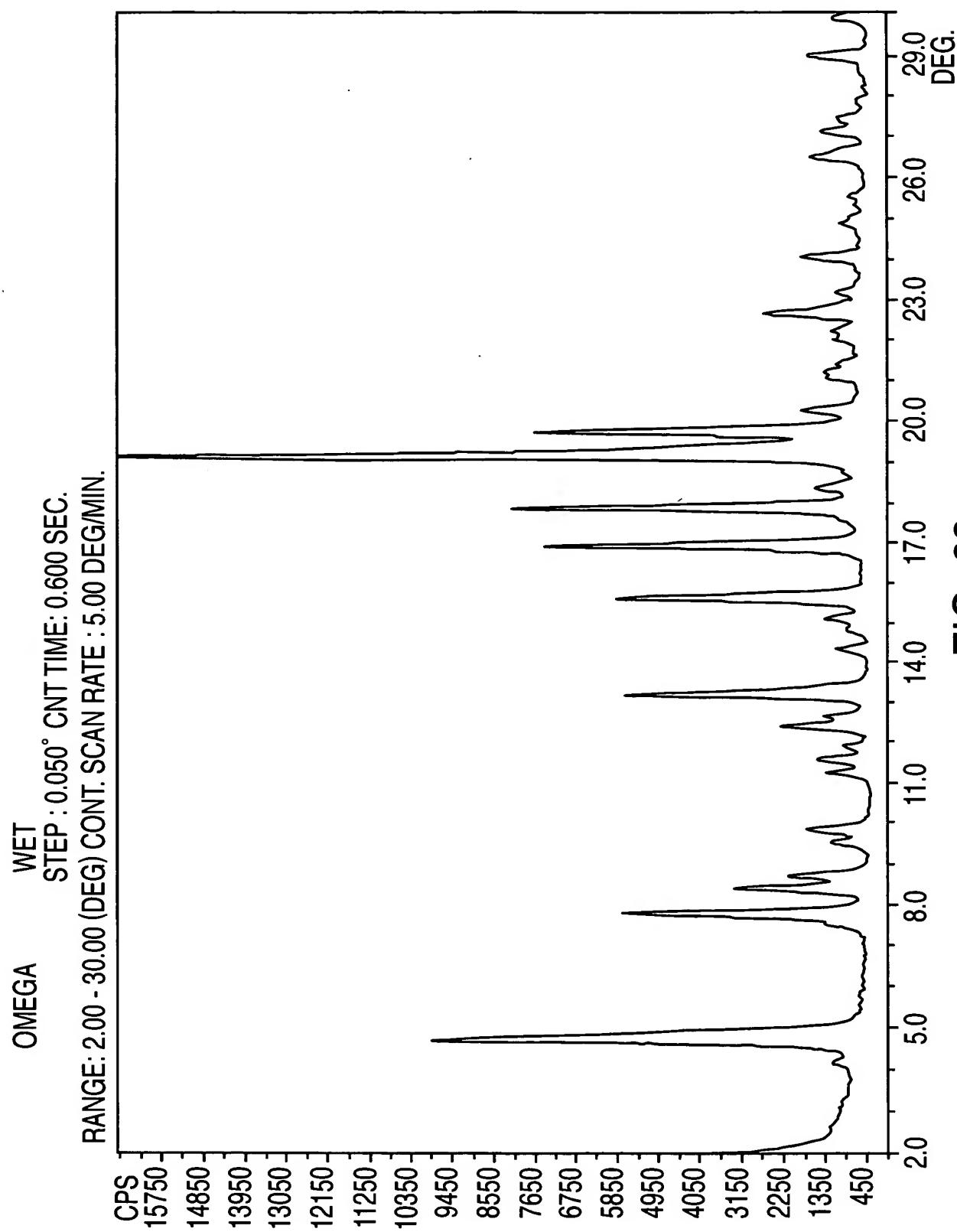


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]								
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	Isopropyl Ester (1.76)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04	
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01	0.03	0.02	

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64